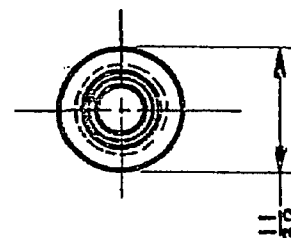
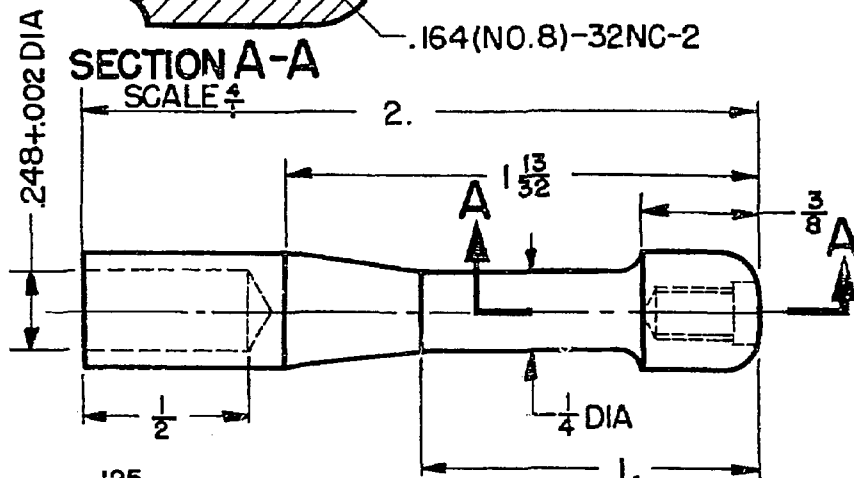


SECTION A-A

SCALE 4/



NOTE:
FINISH ALL OVER $\sqrt{125}$

PHYSICAL PROPERTIES		A 5152734			
YP		REVISIONS			
TS					
EL 2		SYM	DESCRIPTION	DATE	APPROVAL
RA		4	WAS A152734	12-8-50	CWA
BH		A	SEE ERR HQR 30732	25SEP73	R. W. Robinson
RH					

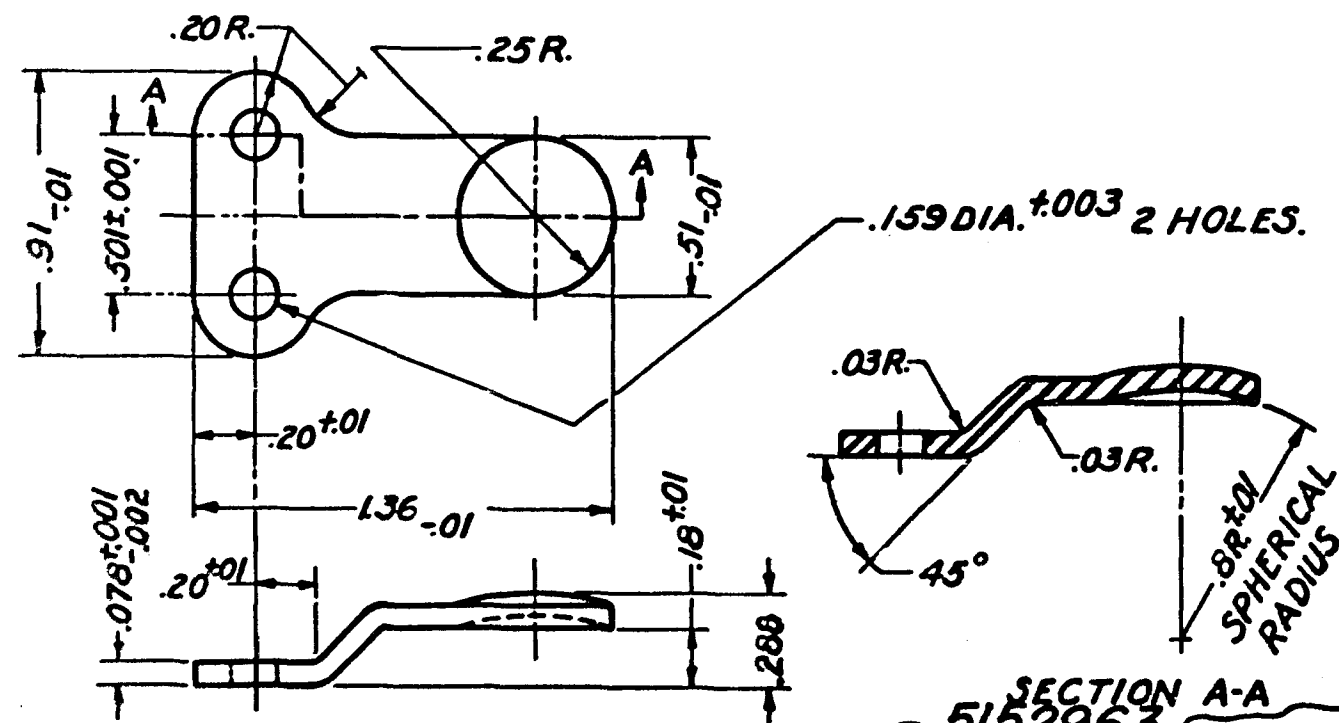
PART NO. 5152734

APPLICATION		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON— DECIMALS FRACTIONS $\pm 1/64$ ANGLES MATERIAL ST FS1018, FS1022 SPEC QQ-S-633 HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING DEC 10, 1937	HEAD, CLEANING ROD	ORDNANCE DEPT DEPT OF THE ARMY ROCK ISLAND ARSENAL
NEXT ASSY C5564183	USED ON ROD CLEANING SUB MACHINE GUN		DRAFTSMAN GAF TRACER DVK ENGINEER		
DO NOT APPLY PART NO.		SUBMITTED Harold A. Carlson ORD DEPT			
AS SPECIFIED		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE Walter A. Beckman ORD DEPT			
			SCALE 2/4	UNIT WT .05	DWG SIZE A
					SHEET OF

A152963

A5152963

HEAT TREATMENT & FINAL FINISH			PHYSICAL PROPERTIES				OCTOBER 20, 1941			
			Y.P.		RED.		ROCK.	B-62	REVISIONS	
			T.S.		BR.				1	CONVERSION 12-17-51
			EL2							



GUARD WINDING KEY LATCH

STEEL-WD.1010

FINISH "F"

MANUFACTURING COMPONENT

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE?

A 5152963 A152963

REF: UNITED AIR CLEANER CO. DRG. NO. 50,013

DR'G. PERTAINS TO
D35505 MAGAZINE, DRUM,
50 CARTRIDGE.
C64362 KEY, WINDING, ASM.

D'FTSMAN V.H.H. TRACER H.M.F. L'DG. D'FTSMAN B.J.H.
CHECKER E.A. CHIEF D'FTSMAN
SUBMITTED:

LT. COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:
COL. ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

SUPERSEDES A152963

A152964

A 5152964

HEAT TREATMENT & FINAL FINISH

HEAT TO 1420°F. QUENCH IN OIL.
DRAW AT 770°F.

PHYSICAL PROPERTIES

Y.P.		RED.		ROCK.	C-43-45
T.S.		BR.			
EL2					

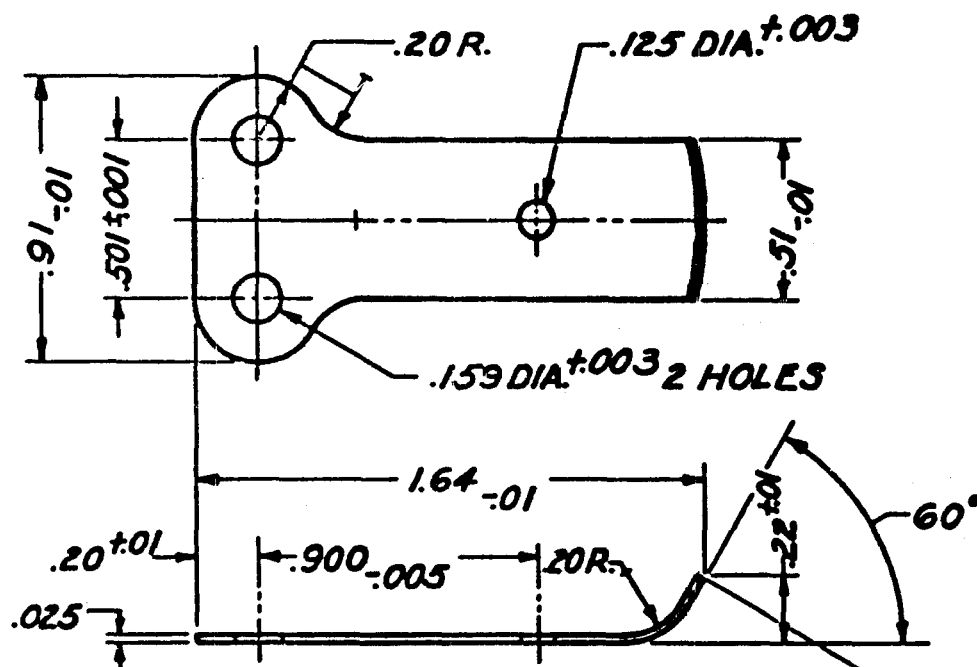
OCTOBER 20, 1941

REVISIONS

1	CONVERSION 10-17-51		

DRG. PERTAINS TO

D35505 MAGAZINE, DRUM,
50 CARTRIDGE
B147656 LATCH, WINDING
KEY, ASSEMBLY



LATCH, WINDING KEY
STEEL W.D. 1075 SPECIAL
FINISH 'F'
MANUFACTURING COMPONENT

5152964

A152964

REF: UN AIR CL CO DRG NO 50,009

TOLERANCES* ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED

SCALE 2

A152964

A152964

DFTSMAN V. H. B.	TRACER H. M. F.	L'DG. DFTSMAN B. J. D.
CHECKER B. M.	C.A. E. G. W.	CHIEF DFTSMAN J. A. W.

SUBMITTED:

LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

J. A. W.
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A152964

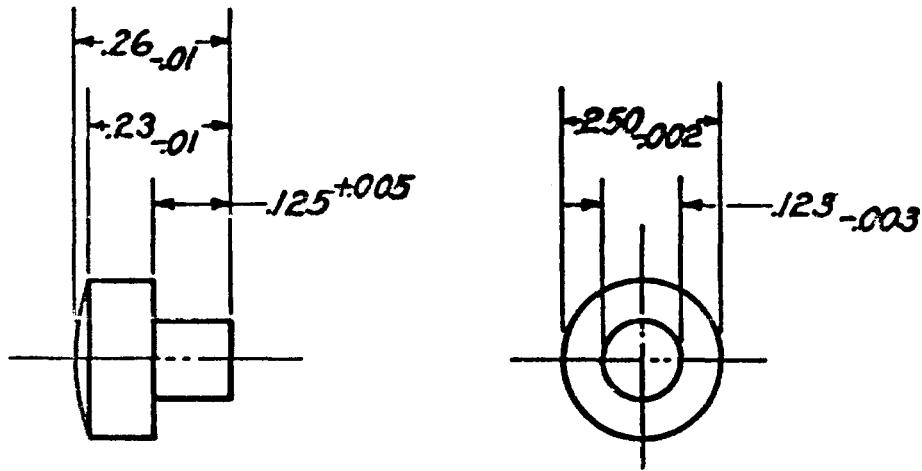
~~A 152965~~

A 5152965

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES					
		Y.P.		RED.		ROCK.	
		T.S.		BR.			
		EL.2					

OCTOBER 20, 1941

REVISIONS			
1 FS	6-12-50		
2	CONVERSION 10-17-51		



DR'G. PERTAINS TO

D35505 MAGAZINE, DRUM,
50 CARTRIDGE
C64358 BODY, MAGAZINE,
ASSEMBLY

DFTSMAN H. H. S.	TRACER H. I. M.	L'DG. DFTSMAN B. J. O.
CHECKER B. H.	CH. DFTSMAN E. G. W.	CHIEF DFTSMAN J. A. M.

SUBMITTED:
Miller & Barton
LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

Johnasuth
COL. ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

PILOT, COVER **5152965**
~~A 152965~~
STEEL FS B1112 FED SPEC QQ-S-633
FINISH $\frac{1}{8}$ "
MANUFACTURING COMPONENT

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 50,001

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{1}{4}$
A 5152965

~~A 152965~~

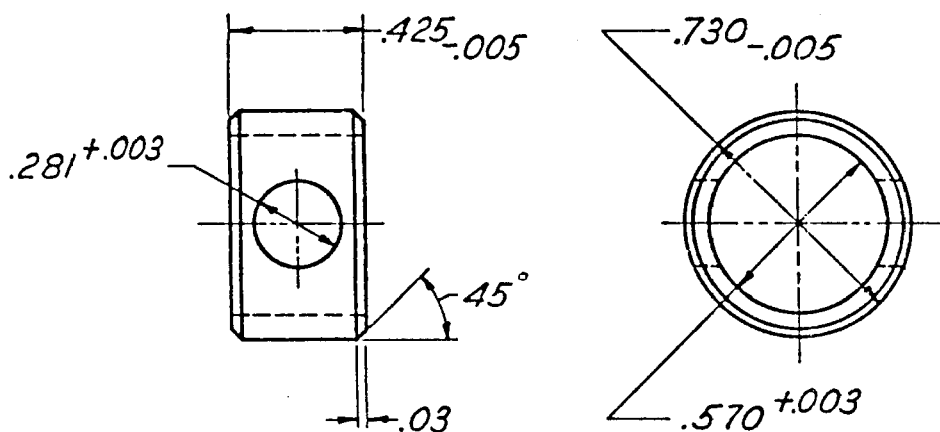
SUPERSEDES A152965

A 5152966

SUPERSEDES A152966

A5152968

HEAT TREATMENT & FINAL FINISH			PHYSICAL PROPERTIES					OCTOBER 20, 1941			
	Y.P.		RED.		ROCK.		REVISIONS				
	T.S.										
	EL.2		BR.				1FS	6-12-50			
							2	CONVERSION 10-17-51			



5152968
RING, HUB ~~A 152968~~
STEEL FS BIII2 FED SPEC QQ-S-633
FINISH "f"
MANUFACTURING COMPONENT

TOLERANCE ±0.1 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$
A5152968

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 50,003

~~A152968~~

[illegible]

SUPERSEDES A152968

~~A-152969~~

[illegible]

-A 152970-

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				OCTOBER 20, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1FS	6-12-50
	EL2					2	CONVERSION 10-17-51
<p style="text-align: center;"> <u>RIVET, RATCHET</u> STEEL FS1010 FED SPEC QQ-S-633 FINISH <i>f</i> </p> <p style="text-align: right;"> REF. DRG. SA 15299 SCALE $\frac{2}{1}$ A 152970 </p>						DR'G. PERTAINS TO	
						D35505	MAGAZINE, DRUM,
							50 CARTRIDGE
						CG4363	RATCHET ASSEMBLY
OFFICER	TRACER	LDC OFFICER					
<i>W.M.F.</i>	<i>W.M.F.</i>	<i>B.H.</i>					
CHECKER	ISA	CHIEF OFFICER					
<i>W.M.</i>	<i>E.G.W.</i>	<i>W.M.</i>					
SUBMITTED:-							
<i>Walter Sinton</i>							
LT. COL. ORD. DEPT. U. S. A.							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-							
<i>John A. Smith</i>							
COL. ORD. DEPT. U. S. A.							
ORDNANCE DEPT., U. S. A.							

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$
A 152970

A 152970

SUPERSEDES A152970

A 5152970

A152985

A5152985

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

DEC. 31, 1941

Y.P.

RED.

ROCK.

T.S.

BR.

EL2

REVISIONS

1 CONVERSION
10-17-51

DR'G. PERTAINS TO

51-63 455MG-M28A1
 B147687 CATCH, BUTT STOCK
 ASSEMBLY

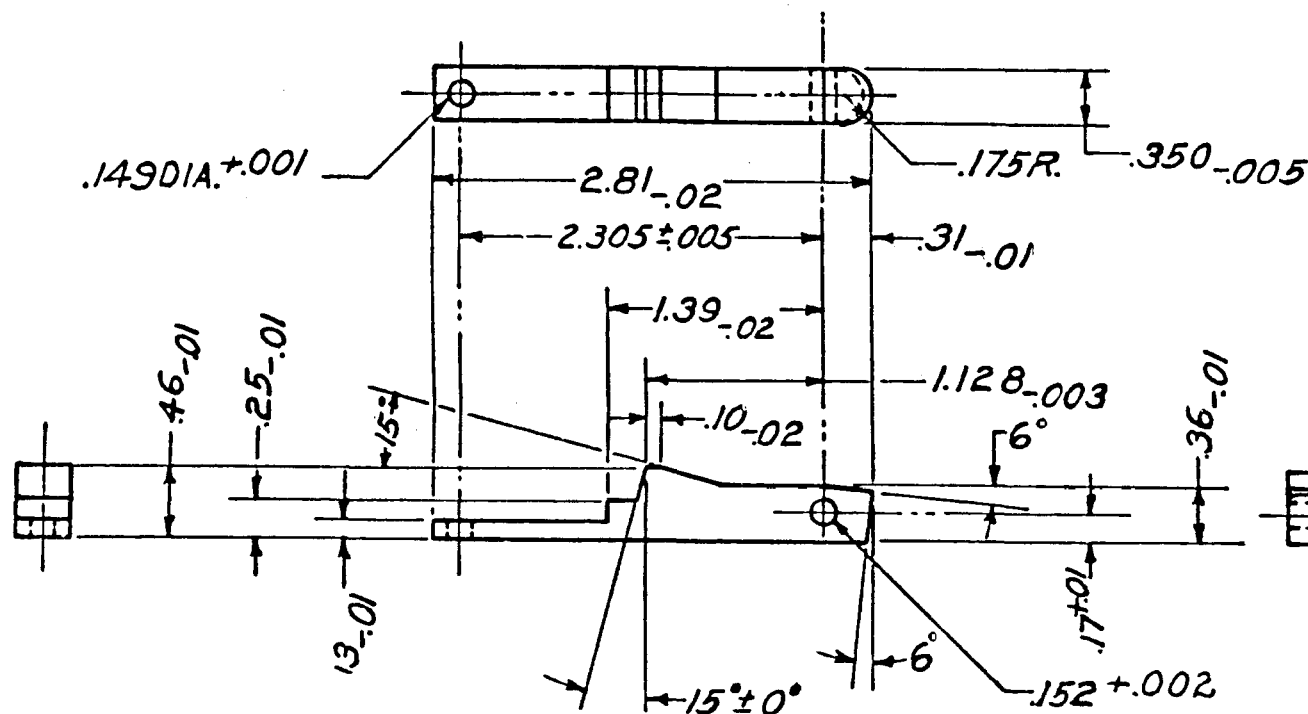
DFTSMAN H.M.F. TRACER W.L.M. L'DG. DFTSMAN B.J.T.
 CHECKER G.M. S.A. CHIEF DFTSMAN J.A. S.A.

SUBMITTED:-

LT. COL ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-J. M. A. B. C.
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



CATCH, BUTT STOCK (A5152985)
 FINISH f
 MANUFACTURING COMPONENT

REF. DRG. A.O.C. 45-6-2

TOLERANCE ±.01 ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.

SCALE 1

A5152985

A152985

SUPERSEDES A152985

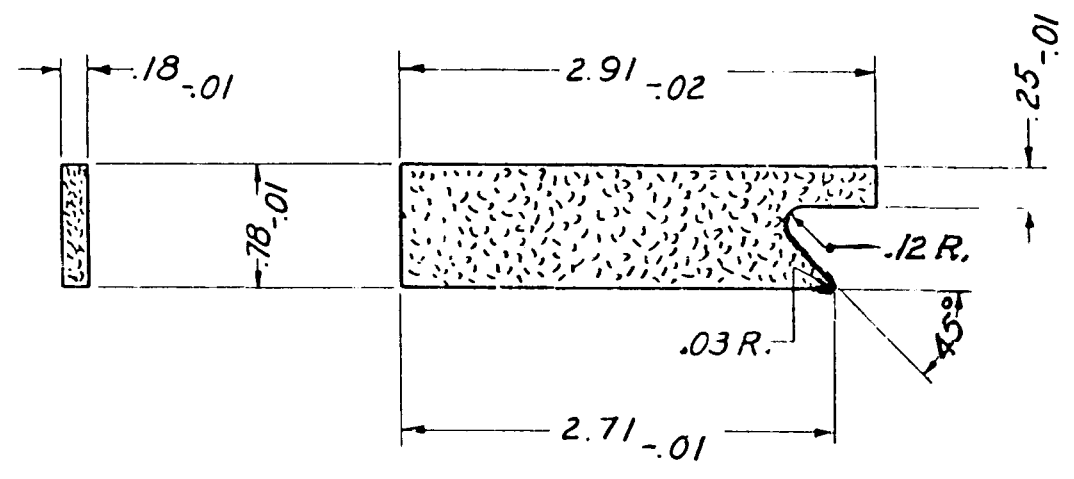
A5152987

SUPERSEDES A152987

A152988

A5152988

HEAT TREATMENT & FINAL FINISH	PHYSICAL PROPERTIES						DEC. 31, 1941			
	Y.P.		RED		ROCK.		REVISIONS			
	T.S.		BR.				1	CONVERSION		
	EL 2							10-17-51		



PAD, BREECH OILER A5152988
MANUFACTURING COMPONENT

DFTSMAN H.M.F.	TRACER H.M.F.	L'DG. DFTSMAN C.F.H.
CHECKER C.M.	SA E.G.W.	CHIEF DFTSMAN J.H. 00

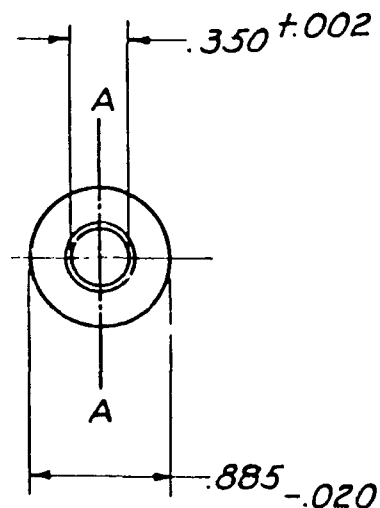
SUBMITTED
William Sinton
LT. COL. ORD DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE
John A. Smith
COL. ORD DEPT. U. S. A.
ORDNANCE DEPT. U. S. A.

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SCALE $\frac{1}{1}$
A5152988

REF. DRG. A.O.C. 45-1-B

A152988

A5152989

[illegible]

5152989
(A) ~~152989~~

SCALE $\frac{2}{1}$

A5152989

A 152989

D'FTSMAN H. M. F.	TRACER H. M. F.	L'DG. D'FTSMAN B. J. O.
CHECKER C. M.	SA F. C. W.	CHIEF D'FTSMAN SA

SUBMITTED: *[Signature]*

[Signature]
LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

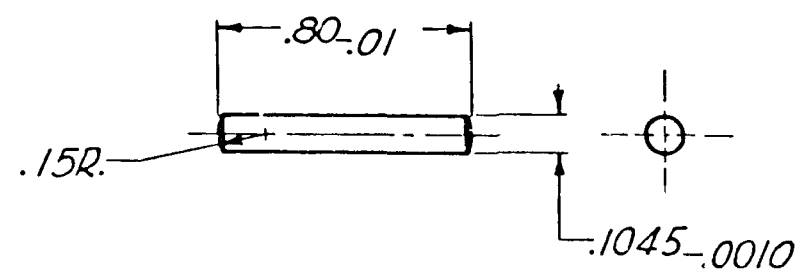
[Signature]
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

~~A 152990~~

A 5152990

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941			
	Y.P.		RED.		ROCK.		REVISIONS		
	T.S.						1	9-30-42	
	EL.2		BR.				2	CONVERSION 10-17-51	



PIN, BUTT PLATE ⁵¹⁵²⁹⁹⁰
~~A 152990~~
 FINISH "f"

DR'G. PERTAINS TO	
51-63	.45 S.M.G.-M28 A1
C64384	PLATE, BUTT, W/
	CAP, ASSEMBLY
51-116	.45 S.M.G.-M1
C113679	PLATE, BUTT W/
	CAP, ASSEMBLY
51-124	.45 S.M.G.-M1A1

DFTSMAN R.B.	TRACER xlc	L'EG. DFTSMAN C.J.O.
CHECKER E.M.	CHIEF DFTSMAN E.G.W.	CHIEF DFTSMAN M.S.A.

SUBMITTED:
[Signature]
 LT. COL. ORD. DEPT., U. S. A.
 APPROVED BY ORDER OF THE
 CHIEF OF ORDNANCE:
[Signature]
 COL. ORD. DEPT., U. S. A.
 ORDNANCE DEPT., U. S. A.

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.


SCALE $\frac{2}{1}$
 A 5152990

REF. DRG. A.O.C. 45-6-4

~~A 152990~~

~~A 152991~~

A 5152991

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						DEC. 31, 1941	
		Y.P.		RED.		ROCK.		REVISIONS	
		T.S.						1	CONVERSION 10-17-51
		EL 2		BR.					
 <p>PIN, BUTT STOCK CATCH FINISH "f"</p> <p>5152991 (A 152991)</p>									
								DR'G. PERTAINS TO	
								51-63	45 SMG-M28A1
								C64387	STOCK, ASSEMBLY
								DFTSMAN	TRACER
H.M.F.	H.M.F.	C.J.F.							
CHECKER	S.A.	CHIEF DFTSMAN							
C.M.	E.G.W.	S.A.							
SUBMITTED:		90							
/ [Signature]									
LT. COL. ORD. DEPT. U. S. A.									
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:									
[Signature]									
COL. ORD. DEPT. U. S. A.									
ORDNANCE DEPT., U. S. A.									

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$

REF. DRG. A.O.C. 45-6-2

A 5152991

~~A 152991~~

~~A 152992~~

A 5152992

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.					1 ²	12-30-43
	EL.2		BR.			2	CONVERSION 10-17-51
						3 ²	9 AUG 54
						DR'G. PERTAINS TO	
						51-63 .45SMG - M2BA1	
						C64386 RECEIVER, W/ BARREL, ASM.	
<p>PIN, FRONT SIGHT A 5152992 5152992</p> <p>FINISH 125/ 3</p>						<p>DFTSMAN TRA. N L'DG. DFTSMAN</p> <p>V.M.S. C.B. C.J.O.</p> <p>CHECKER F.A. CHIEF DFTSMAN</p> <p>E.M. S.A. O.O.</p>	
SUBMITTED:						<p><i>Wm. L. Benton</i></p> <p>LT. COL. ORD. DEPT., U. S. A.</p>	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-						<p><i>John A. Buchs</i></p> <p>COL. ORD. DEPT., U. S. A.</p>	
						ORDNANCE DEPT., U. S. A.	

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$
A 5152992

REF. DRG. A.O.C. 5A

~~A 152992~~

SUPERSEDES A 152992

~~A-152993~~

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941			
	Y.P.		RED.		ROCK.	REVISIONS			
	T.S.		BR.			1	9-30-42		
	EL.2					2	CONVERSION 10-17-51		
DR'G. PERTAINS TO									
						51-63	.45 S.M.G.-M28A1		
						51-116	.45 S.M.G.-M1		
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.		SCALE $\frac{2}{1}$ A5152993		REF. DRG. AO.C. 45-1-16 A-152993		ORDNANCE DEPT., U. S. A.			

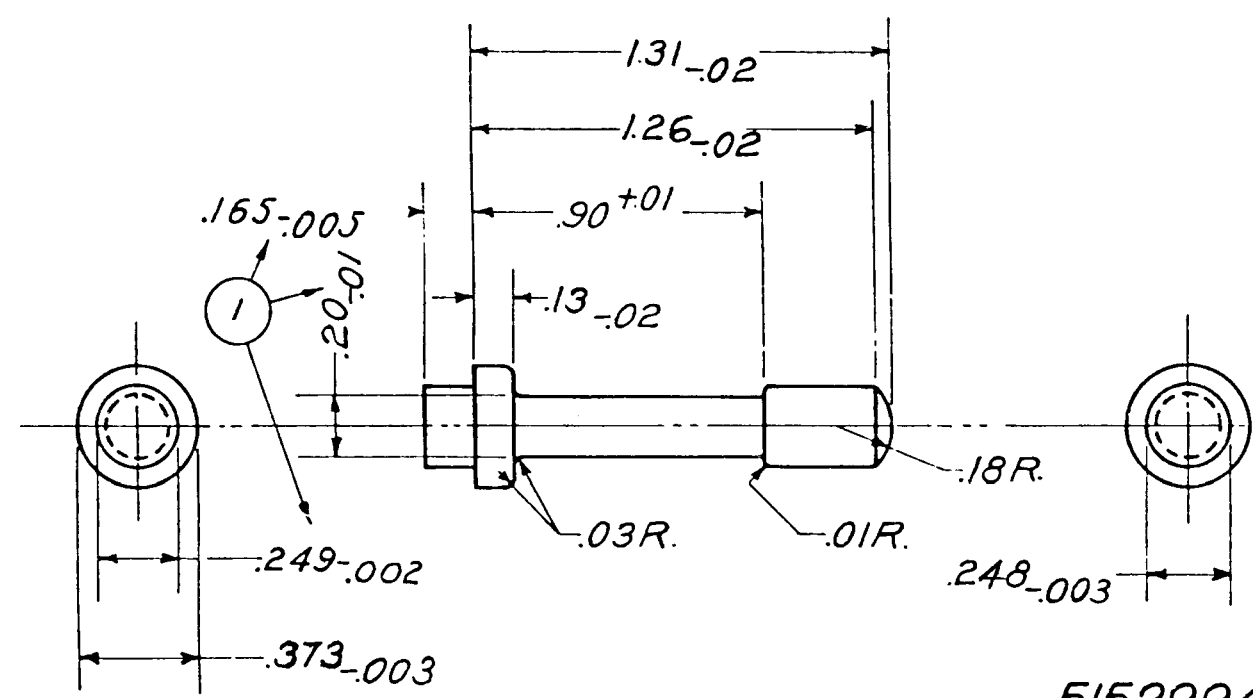
A5152993

DFTSMAN <i>W. J. M.</i>	TRACER <i>W. J. M.</i>	LOG. DFTSMAN <i>C. J. T.</i>
CHECKER <i>W. J. M.</i>	SA. <i>W. J. M.</i>	O.G. <i>W. J. M.</i>
SUBMITTED: <i>W. J. M.</i>		
LT. COL. ORD. DEPT., U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-		
<i>Johnasuch</i> COL. ORD. DEPT., U. S. A.		
ORDNANCE DEPT., U. S. A.		

~~A 152994~~

A5152994

HEAT TREATMENT & FINAL FINISH			PHYSICAL PROPERTIES				DEC. 31, 1941			
			Y.P.		RED.		REVISIONS			
			T.S.			ROCK.	1'	9-30-42		
			EL.2		BR.		2'	12-30-43		
							3	CONVERSION 10-17-51		



PIN, MAGAZINE CATCH (A 5152994)
 FINISH "f"
 MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$
 A5152994

REF. DRG. A.O.C. N42-22-1

~~A 152994~~

DR'G. PERTAINS TO	
51-63	45 S.M.G.-M28A1
51-116	45 S.M.G.-M1
C113653	CATCH, MAGAZINE ASSEMBLY
51-124	45 S.M.G.-M1A1
D'FTSMAN	
H.B.O.	H.L.M.
TRACER	
L'DG D'FTSMAN	
C.H.E.C.K.E.R.	
C.H.I.E.F D'FTSMAN	
SUBMITTED:	
Milled Enten	
LT. COL. ORD. DEPT., U. S. A.	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:	
John A. Nichols	
COL. ORD. DEPT. U. S. A.	
ORDNANCE DEPT., U. S. A.	

CHDCECECE A152994

A5152996

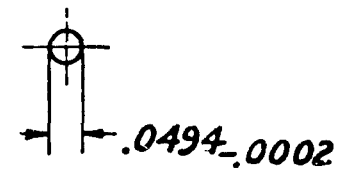
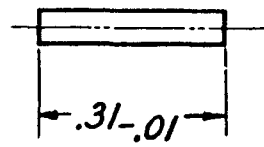
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 19-21	
		Y.P.		RED.		ROCK.	
		T.S.		BR.			
		EL2					
<p style="text-align: center;"> <u>PIN, SIGHT BASE</u> FINISH <i>f</i> </p> <p style="text-align: right;"> A5152995 REE ORGA.O.C. 45-7-2 </p> <p style="text-align: center;">SCALE $\frac{1}{2}$</p>						REVISIONS	
<p>TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.</p>						DR'G. PERTAINS TO	
						51-63	A55.MG-M28A1
<p>OFFICERMAN H.P.O. TRACER H.L.N. LUG OFFICERMAN A.J.G.</p> <p>CHIEF OF ORDNANCE E.S.N. LUG OFFICERMAN J.H.A. W.D.</p> <p>SUBMITTED: <i>[Signature]</i></p> <p>A5152995 REE ORGA.O.C. 45-7-2</p> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>[Signature]</i> LT. COL. ORD. DEPT., U. S. A.</p> <p>ORDNANCE DEPT., U. S. A.</p>							

SUPERSEDES AT 52995

A152996

A5152996

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES					DECEMBER 31, 1941		
		Y.P.		RED.		ROCK.	REVISIONS		
		T.S.		BR.			1	CONVERTED	
		EL.2							



PIN, SIGHT PLUNGER **A5152996**
FINISH
MANUFACTURING COMPONENT

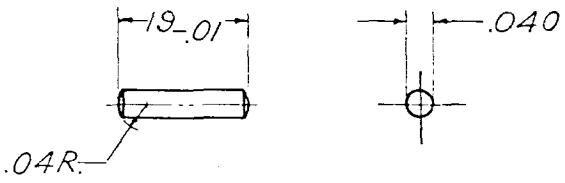
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

A5152996
REF. DRG. A.O.C. 45-7-3

A152996

DFTSMAN H.M.F.	TRACER R. J. G.	LDC DFTSMAN S. J. K.
CHECKER H.A.	E.G.W.	OFFICER J. A. M.
SUBMITTED: J. A. M.		
LT COL. ORD. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: W. J. Moore		
LT. COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

SUPERSEDES A152996

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A152997 DEC. 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	CONVERSION 10-17-51
	EL.2						
 <p>PIN, REAR SIGHT SLIDE STOP 5152997 FINISH "f" A152997</p>						DR'G. PERTAINS TO	
						51-63	.45 S&W-M28A1
						C64382	LEAF, REAR SIGHT, ASM.
DFTSMAN		TRACER		LDC DFTSMAN			
665		668		E. J. O.			
CHECKER		S. A.		CHIEF DFTSMAN			
E. M.		E. G. W.		S. A.		V. J. O.	
SUBMITTED: <i>[Signature]</i>							
LT. COL. ORD. DEPT., U. S. A.							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>[Signature]</i>							
LT. COL. ORD. DEPT., U. S. A.							
ORDNANCE DEPT., U. S. A.							

TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{5}{1}$

A152997
REF. DRG. A.O.C. 45-7-2

A152997

SUPERSEDES A152997

A5152997

A152998

A5152998

DEC. 31, 1941

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

REVISIONS

Y.P.

RED.

ROCK.

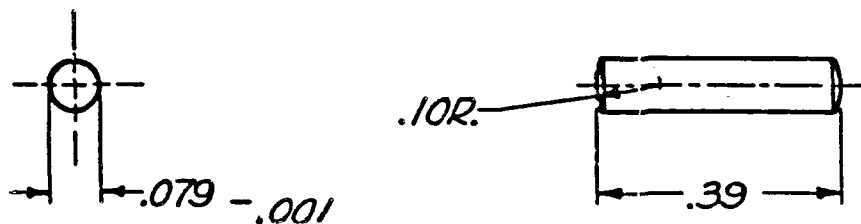
T.S.

BR.

EL2

1 CONVERSION
10-17-31

DR'G. PERTAINS TO

51-63 45SM6-M28A1
B47692 SWIVEL SLING ASM.

PIN, SLING, SWIVEL A 5152998
 FINISH "f"
 MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED. SCALE $\frac{4}{1}$

A5152998
 REF. DRG. 40.C 45-1-24

A152998

DFTSMAN W.L.M. TRACER *ele* L'DG. DFTSMAN *B.F.O.*

CHECKER *C.M.* CHIEF DFTSMAN *J.A.*

SUBMITTED:

LT. COL. ORD. DEPT., U. S. A.

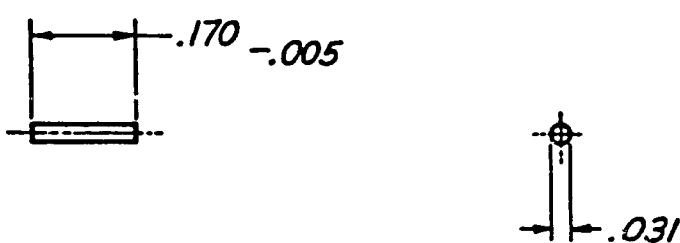
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-

J. H. Smith
 COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A152998

~~A 152999~~

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	CONVERSION 10-17-51
	EL 2						
 <p><u>PIN, WINDAGE SCREW COLLAR</u> A 5152999</p> <p>FINISH <i>f</i></p> <p>TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.</p> <p>SCALE $\frac{4}{1}$</p>						DR'G. PERTAINS TO	
						51-63 .45 S.M.G.-M28A1	
						C64382 LEAF, REAR SIGHT,	
						ASSEMBLY	
						D'FTSMAN	TRACER
H.M.F.	V.M.B.	B.J.C.					
CHECKER	EGW	CHIEF D'FTSMAN					
E.H.	EGW	W.S.A. W.S.A.					
SUBMITTED:-							
<i>[Signature]</i>							
LT. COL. ORD. DEPT., U. S. A.							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-							
<i>[Signature]</i>							
LT. COL. ORD. DEPT., U. S. A.							
ORDNANCE DEPT., U. S. A.							

A 5152999

A 5152999
REF. DRG. A.O.C.-45-7-3

~~A 152999~~

SUPERSEDES A152999

~~A153000~~

A5153000

DECEMBER 31, 1941

HEAT TREATMENT & FINAL FINISH

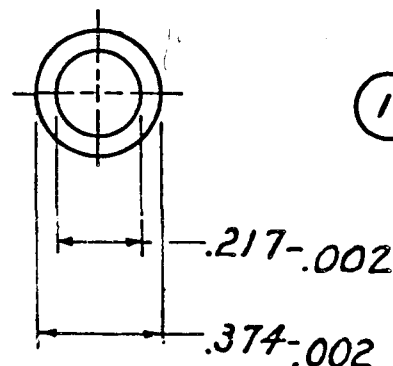
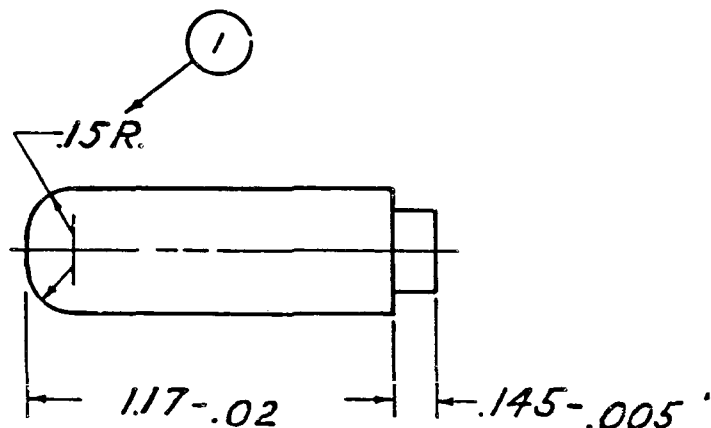
PHYSICAL PROPERTIES

REVISIONS

Y.P.		RED.		ROCK.	
T.S.		BR.			
EL.2					

1' 9-30-42

2 CONVERSION 10-17-51



DR'G. PERTAINS TO

51-63	.45 S.M.G. M28 A1
B147690	PLATE, PIVOT, ASM.
51-116	.45 S.M.G.-M1
51-124	.45 S.M.G.-M1A1

PIVOT, SEAR
FINISH

MANUFACTURING COMPONENT

A5153000
~~A153000~~

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$

A5153000
REF. DRG. A.O.C. N42-24-2

~~A153000~~

D'FTSMAN S.M.	TRACER S.M.	L'DG. D'FTSMAN G.J.T.
CHECKER E.M.	SA E.G.W.	CHIEF D'FTSMAN SA

SUBMITTED:-

Walter B. Barton
LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

John S. Smith
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A153000

A5153001

REVISIONS

1 st	9-30-42
2	CONVERSION 10-17-54

DR'G. PERTAINS TO

51-63	.45 S.M.G.-M28A1
B147690	PLATE, PIVOT, A S M
51-116	.45 S.M.G.-M1
51-124	.45 S.M.G.-M1A1

D'FTSMAN <i>S.M.</i>	TRACER <i>S.M.</i>	L'DG. D'FTSMAN <i>B.J.T.</i>
CHECKER <i>C.M.</i>	USA <i>0.0</i>	CHIEF D'FTSMAN <i>SA</i>

SUBMITTED:

LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

J. H. ...
COL. ORD. DEPT., U. S. A.

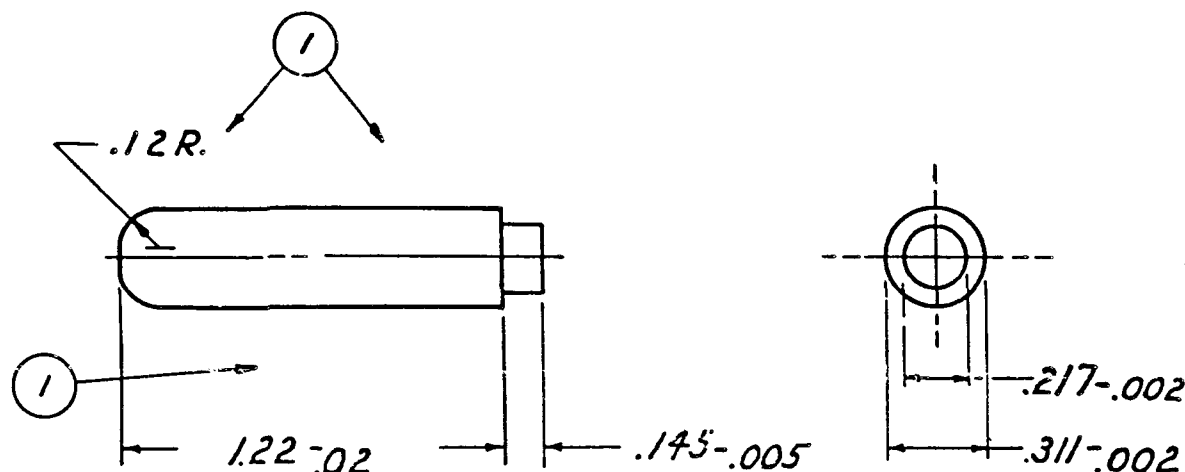
ORDNANCE DEPT., U. S. A.

SUPERSEDES A153001

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y.P.		RED.		ROCK
T.S.		BR.		
EL.2				



PIVOT, TRIGGER (A) ⁵¹⁵³⁰⁰¹
FINISH "X"
MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED

SCALE $\frac{2}{1}$

A5153001
REF. DRG. A.O.C. 42-24-1

~~A/53001~~

A-153002

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DECEMBER 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	20112030W A-17-31
	EL.2						
<p>PLUNGER, SIGHT A-153002 FINISH MANUFACTURING COMPONENT</p>						DR'G. PERTAINS TO	
						51-63	45 SMG-M28 A1
						814769	PLUNGER, REAR
							SIGHT LEAF ASSEM
D'FTSMAN H.M.F.		TRACER R.J.B.		L'DE. D'FTSMAN B.J.C.			
CHECKER E.H.		E.E.W.		CHIEF D'FTSMAN J.A. 128			
SUBMITTED: <i>W. Moore</i>						LT. COL. ORD. DEPT. U. S. A.	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>W. Moore</i>						LT. COL. ORD. DEPT. U. S. A.	
ORDNANCE DEPT. U. S. A.							

A 5153002

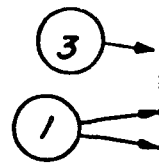
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED

SCALE 2
A5153002 A-153002

REF. DRG. A.Q.C. 45-7-3

A5153004

~~DO~~ INSCRIBE PART NO.
~~DO NOT~~



ORD Div STD
SMALL ARMS

C5613E55

51-63

51-124

REF. DRG. A.O.C. N 42-87
A5153004
A153004

SCALE $\frac{5}{1}$

~~SUPERSEDES A153004~~

A153005

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	9-30-42
	EL.2					2	CONVERSION 10-17-51

SCREW, BUTT PLATE, LARGE
FINISH f

DR'G. PERTAINS TO

51-63	.45 SMG-M28A1
664387	STOCK, ASSEMBLY
51-116	.45 S.M.G.-M1
6113657	STOCK, ASSEMBLY
51-124	.45 SMG-M1A1

DESIGNED BY	TRACED	LDG. DESIGNED
R.B.	H.M.F.	G.P.F.
CHECKED	EA	CHIEF DESIGNED
6.M.	E.G.M.	EA

SUBMITTED:

W.H. Bonta
LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

John A. Bonta
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE 1/1

A5153005
REF. DRG. A.O.C. N42-77

A153005

SUPERSEDES A153005

A5153005

A 5153006

SUPERSEDES A153006

A 5153008

SUPERSEDES A153008

A 153009

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
Y.P.		RED		ROCK		REVISIONS	
T.S.						1	12-30-43
EL 2		BR.					

MAJOR DIA. .2420 ±.0066
PITCH DIA. .2149 ±.0033
MINOR DIA. .1909 MAX

DRG PERTAINS TO

51-63	.45 SMG-M28 A1
64387	STOCK, ASSEMBLY

5153009

SCREW, BUTT STOCK, SMALL (A 153009)

FINISH "f"

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$

REF. DRG A.O.C. 45-6-2

A 153009

ORDNANCE DEPT. U S A

A5153009

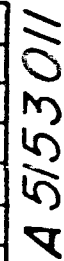
OBSOLETE

A 5153010

SUPERSEDES A153010

A 5153011

A 5153011



5153011
(A) ~~153011~~

A5153011
REF.DRG.A.O.C.N 42-26

~~A 153011~~

DFTSMAN <i>rlc</i>	TRACER <i>H.M.F.</i>	LOG. DFTSMAN <i>C.F.T.</i>
CHECKER <i>C.M.</i>	<i>FF</i> S.A. O. E.G.W.	CHIEF DFTSMAN <i>gta</i> S.A. QO
SUBMITTED: <i>Orrell Carter</i>		
LT. COL. ORD. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE.		
<i>John Asch</i> COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

SUPERSEDES A153011

A5153012

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

DEC. 31, 1941

Y.P.

RED.

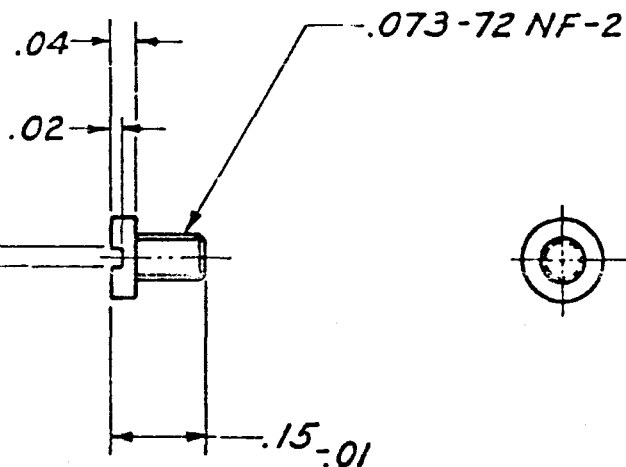
ROCK.

REVISIONS

T.S.

BR.

EL.2

1 CONVERSION
10-17-51

DR'G. PERTAINS TO

51-63 .45 SMG-M28A1

C64382 LEAF, REAR SIGHT, ASM

SCREW, REAR SIGHT SLIDE CATCH
FINISH "f"

5153012
A153012

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{4}{1}$

REF. DRG. A.O.C. 45-7-3

A5153012

A153012

D'FTSMAN H.M.F.	TRACER H.M.F.	L'DG D'FTSMAN G.J.F.
CHECKER G.M.	SA O.O. EGW	CHIEF D'FTSMAN J.S.A. V.M.G.

SUBMITTED:

LT. COL. ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

LT. COL. ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A153012

A153013

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
Y.P.		RED.		ROCK.		REVISIONS	
T.S.		BR.				1	9-30-42
EL2						2	CONVERSION 10-17-51

SCREW, SLING SWIVEL PLATE (A153013)
FINISH "f"

REF. DRG. A.O.C. N42146
A153013

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$

DR'G. PERTAINS TO		
51-63	.45 SMG-M28 A1	
C64387	STOCK, ASSEMBLY	
C64381	GRIP, FORE, HORIZONTAL	
	ASSEMBLY.	
51-116	.45 SMG-M1	
C113657	STOCK, ASSEMBLY	
51-124	.45 SMG-M1A1	

DFTSMAN	TRACER	L'DG. DFTSMAN
H.M.F.	H.M.F.	G.J.P.
CHECKER	CHECKER	CHIEF DFTSMAN
G.M.	S.E.G.W.	S.A.

SUBMITTED:

LT. COL. ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-

COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

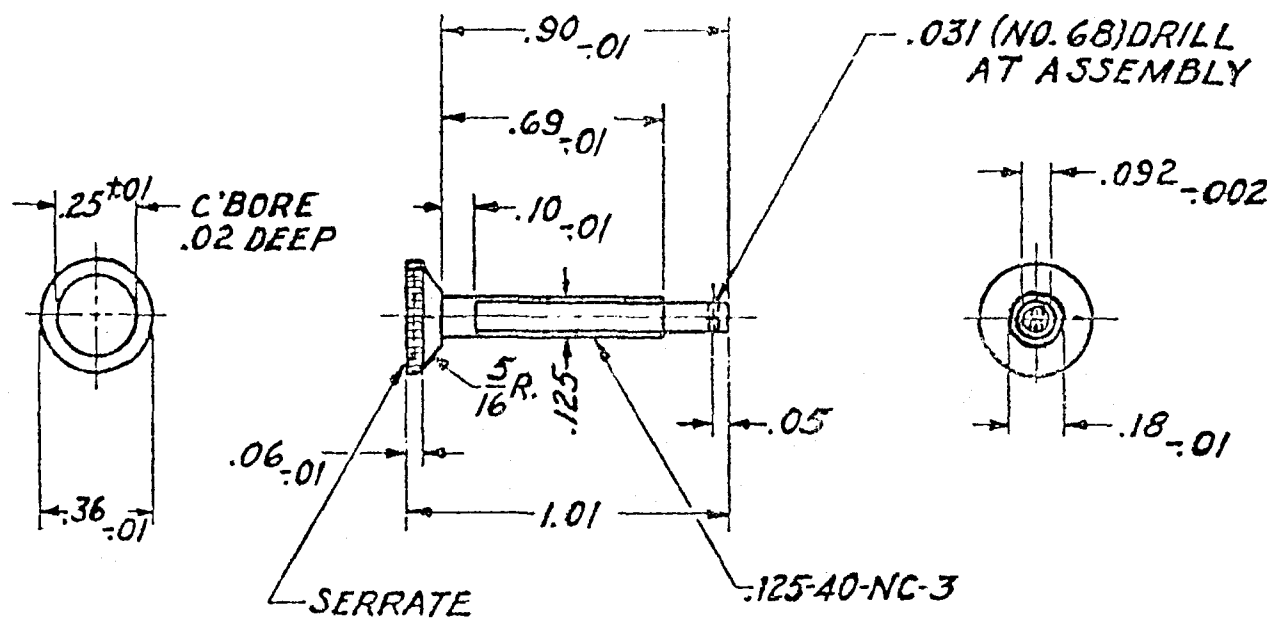
A5153013

SUPERSEDES A153013

~~A153014~~

A5153014

HEAT TREATMENT & FINAL FINISH			PHYSICAL PROPERTIES				DEC. 31, 1941		
			Y.P.		RED.		REVISIONS		
			T.S.				1	CONVERSION	
			EL.2		BR.			10-17-31	



SCREW, WINDAGE
FINISH "f"

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{2}{1}$

REF. DRG. A. O. C. 45-7-3

A5153014

A153014

DFTSMAN H.M.F.	TRACER H.M.F.	L'DG. DFTSMAN G.J.H.
CHEKER E.M.	SA E.G.W.	CHIEF DFTSMAN W.P.
SUBMITTED: W.P. / M.L.P. / E.M.		
LT. COL. ORD. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: W. Moore		
LT. COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

SUPERSEDES A153014

~~A153015~~

A5153015

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC 31, 1941	
		Y.P.		RED.		REVISIONS	
		T.S.		BR.	ROCK.	1	CONVERSION 10-17-51
		EL 2					
<p>NOTE: DRIVE FIT IN COMPENSATOR</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> <p>SIGHT, FRONT FINISH "X"</p> </div> <div style="text-align: center;"> <p>THIS HOLE TO BE DRILLED WITH COMPENSATOR WHEN ASSEMBLED WITH BARREL</p> </div> </div> <p>TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED - SCALE $\frac{2}{1}$</p> <p>REF. DRG. A.O.C. (53) A 5153015</p>						<p>DR'G. PERTAINS TO</p> <p>51-63 45SMG M20A1 C64386 RECIEVER, W/ BARREL, ASM.</p>	
<p>SUBMITTED: <i>Walter D. ...</i> LT. COL. ORD. DEPT., U. S. A.</p> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>J. ...</i> COL. ORD. DEPT., U. S. A.</p> <p>ORDNANCE DEPT., U. S. A.</p>							

SIIPERSEDES A153015

A5153017

SUPERSEDES A153017

A153018

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DECEMBER 31, 1941			
	Y.P.		RED.		ROCK.	REVISIONS			
	T.S.		BR.			1	9-30-42		
	EL 2					2	5-23-44		
						3	CONVERSION 10-17-51		
DIAMETER OF WIRE030 TOTAL NUMBER OF COILS 9 1/2 (2) MINIMUM INSIDE DIAMETER, FREE170 OUTSIDE DIAMETER, FREE230 + .010 MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT241 FREE LENGTH OF SPRING61 TYPE OF ENDS PLAIN WOUND R.H. MEAN ASSEMBLED HEIGHT435 LOAD AT MEAN ASSEMBLED HEIGHT 2.4 LBS. MINIMUM OPERATING HEIGHT32 LOAD AT MINIMUM OPERATING HEIGHT 4 LBS. (2) SPRING FUNCTIONS IN HOLE25 + .01 CALCULATED MAXIMUM SOLID HEIGHT315 (2)						DR'G. PERTAINS TO			
						51-63	.45 SMG-M29A1		
						51-116	.45 SMG-M1		
						51-124	.45 SMG-M1A1		
NOTE:- EXPAND LAST COIL ON ONE END TO OUTSIDE DIA. OF .26 + .01						DFTSMAN <i>C.M.</i> TRACER R.S. LOG DFTSMAN <i>C.M.</i> CHECKER <i>C.M.</i> <i>EGW</i> CHIEF DFTSMAN <i>EGW</i> 0.0 SUBMITTED:- <i>W. H. B. Burt</i> LT. COL., ORD. DEPT., U. S. A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>John A. Burt</i> COL. ORD. DEPT., U. S. A. ORDNANCE DEPT., U. S. A.			

SPRING, DISCONNECTOR

A153018-2
5153018

A5153018

REF. DRG. A.O.C. 45-1-15

A153018

SUPERSEDES A153018

~~A153020~~

A5153020

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						DECEMBER 31, 1941			
		Y.P.		RED.		ROCK.		REVISIONS			
		T.S.		BR.				1'	9-30-42		
		EL2						2	CONVERSION 10-17-31		
DIAMETER OF WIRE026											
TOTAL NUMBER OF COILS 5 1/2											
MINIMUM INSIDE DIAMETER, FREE218											
OUTSIDE DIAMETER, FREE27 + .01											
MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT283											
FREE LENGTH OF SPRING520 ± .010											
TYPE OF ENDS SQUARED											
WOUND R.H.											
MEAN ASSEMBLED HEIGHT32											
LOAD AT MEAN ASSEMBLED HEIGHT 2.4 LBS.											
MINIMUM OPERATING HEIGHT195											
LOAD AT MINIMUM OPERATING HEIGHT 3.87 LBS.											
SPRING FUNCTIONS IN HOLE300 + .003											
SPRING FUNCTIONS OVER ROD200 - .004											
CALCULATED MAXIMUM SOLID HEIGHT17											
REDUCE LAST COIL ON ONE END TO OUTSIDE DIA. OF .23 + .01. EXPAND LAST COIL ON OTHER END TO .32 + .01. O.D.											
5153020											
SPRING, FRAME LATCH											
A5153020											
REF. DRG. A.O.C. A45-1-9											
A153020											
DR'G. PERTAINS TO											
51-63 .45 SMG-M28A1											
51-116 .45 SMG-M1											
31-124 .45 SMG-M1A1											
DFTSMAN TRACER L'DG. DFTSMAN											
C.M. R.S. C.J.T.											
CHECKER E.G.W. G.W. S.A. O.O.											
SUBMITTED:											
/mld/entn											
LT. COL., ORD. DEPT., U. S. A.											
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-											
John A. Smith											
COL., ORD. DEPT., U. S. A.											
ORDNANCE DEPT., U. S. A.											

SUPERSEDES A153020

[illegible]

SUPERSIDES A153021

A153022

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DECEMBER 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.					1	CONVERSION 10-17-51
	EL.2		BR.				
DIAMETER OF WIRE031 TOTAL NUMBER OF COILS 18 MINIMUM INSIDE DIAMETER, FREE108 OUTSIDE DIAMETER, FREE17 \pm .01 MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT .. .182 FREE LENGTH OF SPRING 1.20 \pm .02 TYPE OF ENDS GROUND WOUND L.H. MEAN ASSEMBLED HEIGHT95 MINIMUM LOAD AT MEAN ASSEMBLED HEIGHT 8.6 LBS. MINIMUM OPERATING HEIGHT8 MINIMUM LOAD AT MINIMUM OPERATING HEIGHT 10.8 LBS. SPRING FUNCTIONS IN HOLE200 \pm .001 CALCULATED MAXIMUM SOLID HEIGHT56							
						DR'G. PERTAINS TO	
						51-63	.45 SMG-M28A1
SPRING, REAR SIGHT PLUNGER						DFTSMAN B.M. TRACER R.S. L'DG. DFTSMAN B.F.C. CHECKER B.M. CHIEF DFTSMAN EGW SUBMITTED: LT. COL., ORD. DEPT., U. S. A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- LT. COL. ORD. DEPT., U. S. A. ORDNANCE DEPT., U. S. A.	

5153022

A5153022

REF. ORG. A.O.C. 45-7-3

A153022

SUPERSEDES A153022

A5153022

~~A-153023~~

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
		Y.P.		RED.		REVISIONS	
		T.S.		BR.		1	CONVERSION M-17-3
		EL2					
						DR'G. PERTAINS TO	
						51-63	45 S.M.G.-M28A1
						BATCH CATCH, REAR SIGHT	
						SLIDE, ASSEMBLY	
<p><u>SPRING, REAR SIGHT SLIDE CATCH</u> 5153023</p> <p>FINISH <i>f</i></p> <p>MANUFACTURING COMPONENT</p>						<p>DFTSMAN <i>H.M.F.</i> TRACER <i>V.W.R.</i> L'DG. DFTSMAN <i>S.J.C.</i></p> <p>CHECKER <i>S.M.</i> <i>EGW</i> CHIEF DFTSMAN <i>J.A.I.</i> <i>W.C.</i></p>	
<p>TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.</p>						<p>SUBMITTED: <i>[Signature]</i></p> <p>LT. COL. ORD. DEPT., U. S. A.</p>	
<p>SCALE $\frac{2}{1}$</p>						<p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>[Signature]</i></p> <p>LT. COL. ORD. DEPT., U. S. A.</p>	
<p>REF. DRG. A.O.C. 45-7-3</p> <p>5153023</p> <p>A 153023</p>						<p>ORDNANCE DEPT., U. S. A.</p>	

A 153024

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DECEMBER 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.					1	CONVERSION 10-17-51
	EL2		BR.				
DIAMETER OF WIRE042 TOTAL NUMBER OF COILS 68 OR 69 MINIMUM INSIDE DIAMETER, FREE301 OUTSIDE DIAMETER, FREE385 + .006 MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT399 FREE LENGTH OF SPRING 11 5/16 ± 5/16 TYPE OF ENDS PLAIN WOUND L.H. MEAN ASSEMBLED HEIGHT 7.45 LOAD AT MEAN ASSEMBLED HEIGHT 6 LBS. 12 OZ. MINIMUM OPERATING HEIGHT 3.5 LOAD AT MINIMUM OPERATING HEIGHT 14 LBS. 6 OZ. SPRING FUNCTIONS IN HOLE406 + .005 SPRING FUNCTIONS OVER ROD290 - .005 CALCULATED MAXIMUM SOLID HEIGHT 2.9						DR'G. PERTAINS TO	
						51-63	.45 SMG-M28A1
DFTSMAN <i>C.M.</i> TRACER R.S. L'DG. DFTSMAN <i>C.M.</i> CHECKER <i>C.M.</i> <i>EGW</i> CHIEF DFTSMAN <i>EGW</i> S.A. Q.O. SUBMITTED: <i>Walter Hinton</i> LT. COL., ORD. DEPT., U. S. A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>John A. Smith</i> COL. ORD. DEPT., U. S. A. ORDNANCE DEPT., U. S. A.							

SPRING, RECOIL

5153024
A153024

A5153024

REF. DRG. A.O.C. N45-1-21

A153024

SUPERSEDES A153024

A5153024

A153025

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DECEMBER 31, 1941	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	9-30-42
	EL2					2	CONVERSION 10-17-51
DIAMETER OF WIRE035 TOTAL NUMBER OF COILS 9 1/2 MINIMUM INSIDE DIAMETER, FREE152 OUTSIDE DIAMETER, FREE232 - .010 MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT234 FREE LENGTH OF SPRING765 + .020 TYPE OF ENDS PLAIN WOUND R.H. MEAN ASSEMBLED HEIGHT56 LOAD AT MEAN ASSEMBLED HEIGHT 5.7 LBS. MINIMUM OPERATING HEIGHT50 LOAD AT MINIMUM OPERATING HEIGHT 7.28 LBS. SPRING FUNCTIONS IN HOLE248 + .010 CALCULATED MAXIMUM SOLID HEIGHT37						DR'G. PERTAINS TO 51-63 .45 SMG-M2BA1 51-116 .45 SMG-M1 51-124 .45 SMG-M1A1	
NOTE:- EXPAND LAST COIL ON ONE END TO OUTSIDE DIA. OF .265 + .010						OFFSMAN <i>E.M.</i> TRACER R.S. LOG OFFSMAN <i>B.J.F.</i> CHECKER <i>E.M.</i> <i>E.P.W.</i> CHIEF OFFSMAN <i>B.A.</i> O.O. SUBMITTED:- <i>Walter E. Sinton</i> LT. COL., ORD. DEPT., U. S. A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>John A. Smith</i> COL. ORD. DEPT., U. S. A. ORDNANCE DEPT., U. S. A.	

SPRING, SEAR

5153025

~~A153025~~

A5153025

REF. ORG. A.O.C. A45-1-9

~~A153025~~

SUPERSEDES A15302

A 5153026

SUPERSEDES A153026

A 5153027

SUPERSEDES A153027

~~A 153028~~

A 5153028

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
Y.P.		RED.		ROCK.		REVISIONS	
T.S.		BR.				1	CONVERSION RD-17-31
EL2							
						DR'G. PERTAINS TO	
						51-63	45 SMG-M28A1
						BI47688	CATCH, REAR SIGHT
							SLIDE, ASSEMBLY
<p>STUD, REAR SIGHT SLIDE CATCH 5153028</p> <p>FINISH f A 153028</p> <p>MANUFACTURING COMPONENT</p>						<p>5153028</p> <p>REF. DRG. A.D.C. 45-73</p> <p>A 153028</p>	
<p>TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.</p> <p>SCALE $\frac{4}{1}$</p>						<p>ORDNANCE DEPT. U. S. A.</p>	

OFFSMAN H.M.F.	TRACER H.M.F.	L'DE OFFSMAN S.P.C.
CHECKER B.M.	CHIEF OFFSMAN S.P.C.	CHIEF OFFSMAN S.P.C.
SUBMITTED W. Moore		
LT. COL. ORD. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: W. Moore		
LT. COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

B5153029

REVISIONS			
SYN	DESCRIPTION	DATE	APPROVAL
2		9-10-51	<i>W. J. Grant</i>
A	REDRAWN AND REVISED, SEE EO SA 24435	15 JAN 58	<i>W. J. Grant</i>
B1	SEE EO NO. SA 25395	16 OCT 58	<i>W. J. Grant</i>
C5	SEE EO NO. SA 25915	23 NOV 60	<i>W. J. Grant</i>
D	(1-3) SEE EO NO. SA 27712	30 OCT 64	<i>W. J. Grant</i>
E	(1-2) SEE EO NO. SA 29433	22 JUL 66	<i>W. J. Grant</i>
F	SEE EO RIA-14017	3-15-67	<i>W. J. Grant</i>
G	(1-2) SEE EO 82000	5 FEB 68	<i>W. J. Grant</i>
H	(2) SEE ERR HQR 30602	8 JAN 73	<i>W. J. Grant</i>
J	ERR Z9Z1167B (ECP W952019/790627)	891005	<i>W. J. Grant</i>

NOTES:

1. FINAL PROTECTIVE FINISH:
FINISH 5.3.1.2 OF MIL-STD-1712. DIMENSIONS APPLY AFTER ASSY
WITH PLATE B6147716

3. MATERIAL:

STEEL, SPEC ASTM A575 AND A675 OR ASTM A108;
1010, 1015, 1020. WIRE, STEEL, FED. SPEC QQ-W-461;
101Q, 1015, 1020, FINISH 1, TEMPER HARD OR ANNEALED-IN-PROCESS.

4. FINISH 125/

5. MIL-W-13855 APPLIES.

CURRENT DESIGN ACTIVITY CASE CODE 18000
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

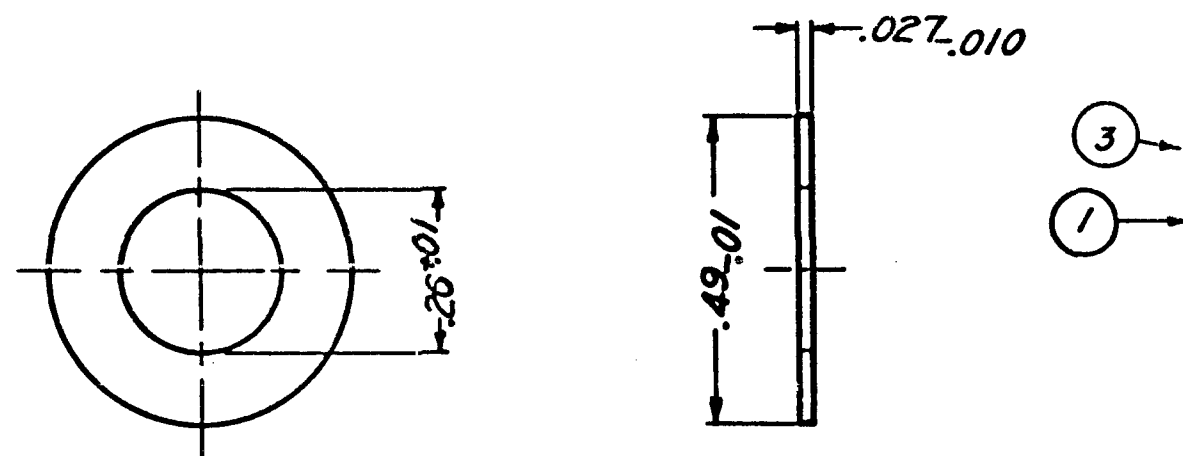
PART NO. 5153029

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING	31 DEC 41	
DIMENSIONS ARE IN INCHES		TOLERANCES: ON FRACTIONS DECIMALS ANGLES				
± 1/64						
MATERIAL		SEE NOTE 3				
HEAT TREATMENT						
FINAL PROTECTIVE FINISH		SEE NOTE 1				
APPROVED BY ORDER OF THE		CHIEF OF ENGINEERING				
H. J. Lynch		DND CORPS				
CODE IDENT NO 19205		SCALE 2/1		UNIT WT		
B		SHEET 1		OF 1		

LAUNCHER,	M 79
B6147721	M 79
NEXT ASSY	USED ON
DO NOT	APPLY PART NO.
00	AS SPECIFIED

SWIVEL, SLING	SPRINGFIELD ARMOY, SPRINGFIELD, MA. 01101
5153029	

A-153030

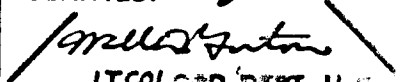
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				DEC. 31, 1941	
Y.P.		RED.		ROCK.		REVISIONS	
T.S.		BR.				1' 9-30-42	
EL.2						2' CONVERSION 9-0-51	
 <p>WASHER, BUTT STOCK SCREW FINISH "f"</p>					3' 2-18-52		
<p>51-63</p> <p>51-116</p> <p>51-124</p>							
<p>REF. DRG. A.O.C. 45-6-2</p> <p>A5153030</p> <p>A153030</p>							

DO NOT INSCRIBE PART NO.


DR'G. PERTAINS TO

ORD DIV STD
SMALL ARMS

DFTSMAN H.M.F.	TRACER Xlc	L.DG. OFFICIAL G. J. O.
CHIEF G.M.	CHIEF G.M.	CHIEF G.M.

SUBMITTED:

LT. COLORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-


COL. ORD. DEPT. U. S. A.
ORDNANCE DEPT., U. S. A.

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE 4/1

SUPERSEDES A153030

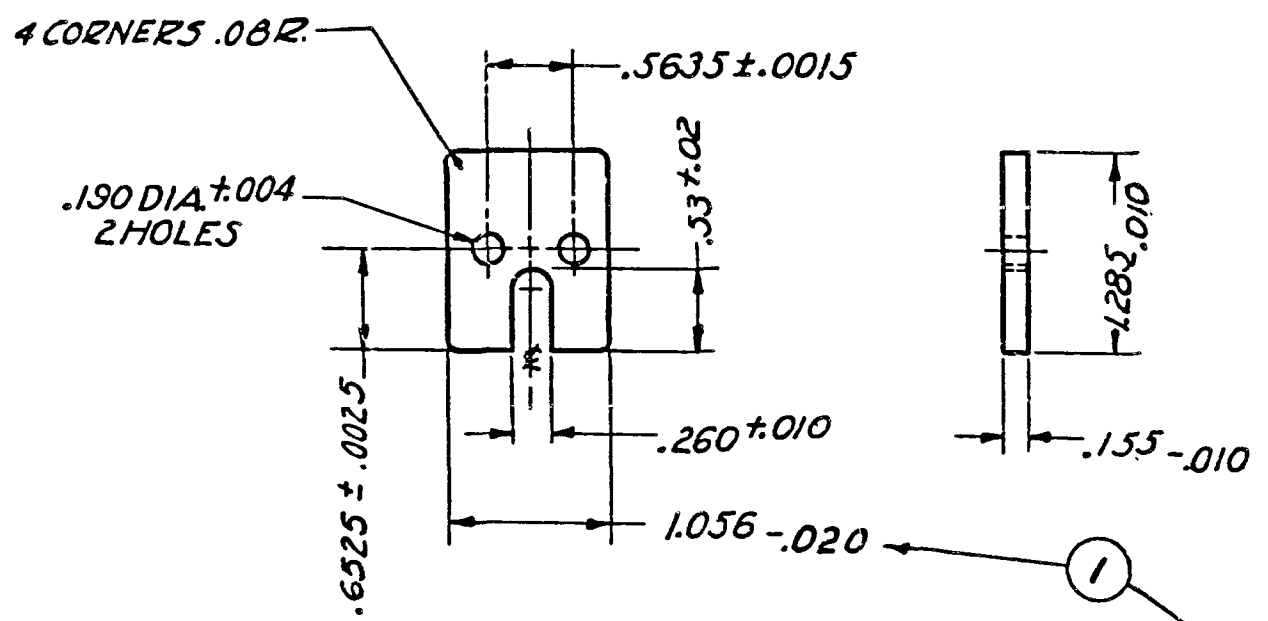
A5153030

Δ 5153756

SUPERSEDES A153056

A5153057

HEAT TREATMENT & FINAL FINISH			PHYSICAL PROPERTIES						APRIL 30, 1942		
	Y.P.		RED.		ROCK.		REVISIONS				
	T.S.		BR.			1'	10-9-43				
	EL 2					2	CONVERSION 10-17-51				



PAD, BUFFER
MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{1}{4}$
A 5153057

REF. DRG A.O.C-A-42-A-111
SPRINGFIELD ARMORY

~~A153057~~

DR'G. PERTAINS TO		
51-116	45 S.M.G.-MI	
B147718	BUFFER, ASSEMBLY	
51-124	45 S.M.G. MIAI	
D'FTS MAN J.P.	TRACER J.P.	L'DG. D'FTS MAN C.F.T.
CHECKER C.N.	CHIEF D'FTS MAN S.A.	O.O.
SUBMITTED:-		
<i>Miller G. L.</i> COL., ORD. DEPT.,		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-		
<i>Johnas L. Smith</i> COL., ORD. DEPT., U. S. A.		
ORDNANCE DEPT., U. S. A.		

SUPERSEDES A153057

A153059

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				APRIL 30, 1942	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1'	12-30-43
	EL.2					2	CONVERSION 9-10-51
						3'	2-18-52
						DR'G. PERTAINS TO ORD. DIV. STD SMALL ARMS	
						C5613655 C5564385 51-116 .45 SMG. - M1 51-124 .45 S.M.G. - M1A1 51-63 .45 S.M.G. - M28A1	
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.						SUBMITTED / <i>Walter G. Eaton</i> COL., ORD. DEPT.	
						APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>J. H. ...</i> COL., ORD. DEPT., U. S. A. ORDNANCE DEPT., U. S. A.	

REF. DRG. A.O.C. N42-54

SPRINGFIELD ARMORY

A5153059

A153059

SCALE: $\frac{2}{1}$

SHEDDENSE A153059

A153065

A5153065

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				APRIL 30, 1942	
	Y.P.		RED.		ROCK.	REVISIONS	
	T.S.		BR.			1	12-30-43
	EL2					2	CONVERSION 10-17-51
<p>MAJOR DIA. .2420-.0066 PITCH DIA. .2149-.0033 MIN. DIA. .1909 MAX.</p> <p>SCREW, BUTT STOCK, SMALL FINISH "f"</p> <p>A5153065 5153065</p> <p>REF. DRG. A.O.C. N42-69 SPRINGFIELD ARMORY</p> <p>TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED SCALE: $\frac{1}{1}$</p> <p>A153065</p>						DR'G. PERTAINS TO	
						51-116	45 S.M.G.-M1
						51-124	45 S.M.G.-M1A1
						51-63	45 S.M.G.-M28A1
						C64387	STOCK ASSEMBLY
						DFTSMAN	
						TRACER	
						L'DG. DFTSMAN	
						CHECKER	
						CHIEF DFTSMAN	
SUBMITTED:							
COL., ORD. DEPT.							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-							
COL., ORD. DEPT., U. S. A.							
ORDNANCE DEPT., U. S. A.							

SUPERSEDES A153065

A153066

APRIL 30, 1942

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

REVISIONS

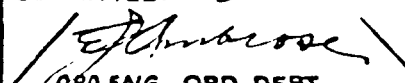

Y.P.		RED.		ROCK.	
T.S.		BR.			
EL2					

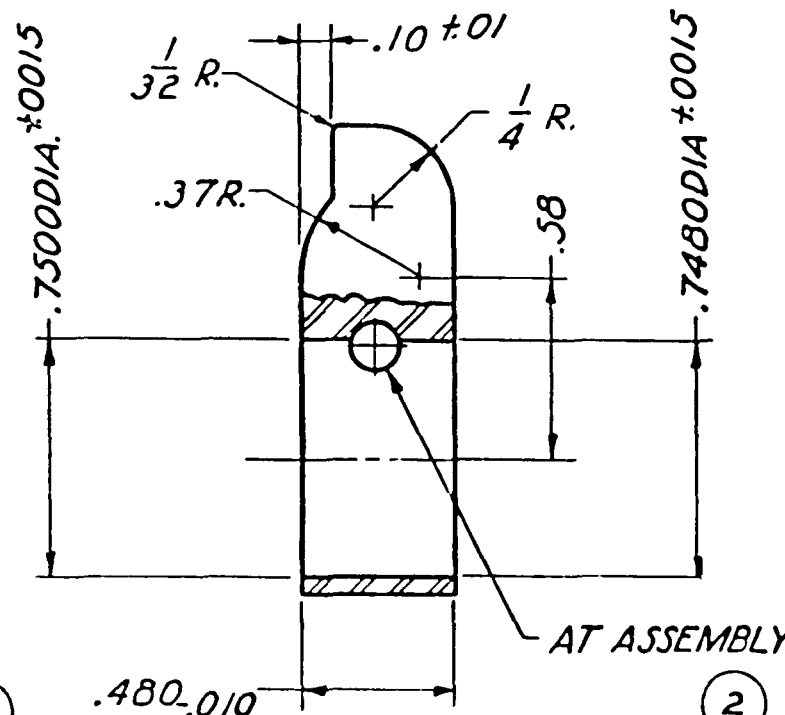
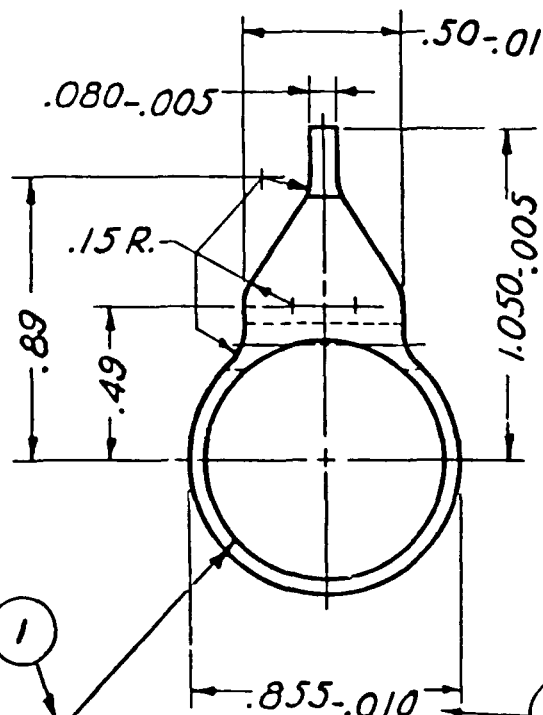
1'	7-28-43		
2 ²	10-9-43		
3'	12-30-43		
4	10-17-51		

DR'G. PERTAINS TO

51-116	.45 S.M.G.-M1
C113656	RECEIVER, W/ BARREL, ASM.
51-124	.45 S.M.G.-M1A1
51-63	.45 S.M.G.-M28A1
C64386	RECEIVER, W/BARREL, ASS'Y.

D'FTSMAN JAP.	TRACER JAP.	L'DG. D'FTSMAN B. J. T.
CHECKER J. M.	0.0	CHIEF D'FTSMAN E. G. W.

SUBMITTED:-

 ORD. ENG., ORD. DEPT.
 APPROVED BY ORDER OF THE
 CHIEF OF ORDNANCE:-

 COL., ORD. DEPT.
 ORDNANCE DEPT., U. S. A.



OPTIONAL METHOD

THIS HOLE MAY BE STRAIGHT
 .7485 DIA. ± .0010 INSTEAD OF
 TAPERED.

TOLERANCE ± .01 ALLOWED ON ALL DIMEN-
 SIONS UNLESS OTHERWISE SPECIFIED.

SIGHT, FRONT
 FINISH "f"

REF. A.O.C. N 42-53
 SPRINGFIELD ARMORY

SCALE $\frac{2}{1}$
 A5153066

SUPERSEDES A153066

A5153066

A5153115

SUPERSEDES A153115

HEAT TREATMENT & FINAL FINISH

DIAMETER OF WIRE042
 TOTAL NUMBER OF COILS 68 OR 69
 MINIMUM INSIDE DIAMETER, FREE301
 OUTSIDE DIAMETER, FREE385 + .006
 MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT399
 FREE LENGTH OF SPRING 11 5/16 ± 5/16
 TYPE OF ENDS PLAIN
 WOUND L.H.
 MEAN ASSEMBLED HEIGHT 7.68
 LOAD AT MEAN ASSEMBLED HEIGHT 5 LBS. 12 OZ.
 MINIMUM OPERATING HEIGHT 3.87
 LOAD AT MINIMUM OPERATING HEIGHT 11 LBS. 12 OZ.
 SPRING FUNCTIONS IN HOLE415 + .010
 SPRING FUNCTIONS OVER ROD289 - .010
 CALCULATED MAXIMUM SOLID HEIGHT 2.99

SPRING, RECOIL **A5153116**
~~A153116~~

A5153116
 REF. DRG. A.O.C. N42-49

~~A153116~~

~~A153116~~

APRIL 30, 1942

REVISIONS

1	CONVERSION		
	10-17-51		

DRG. PERTAINS TO

51-116	.45 S.M.G.-M1
51-124	.45 S.M.G.-M1A1

DFTSMAN E.H.M.	TRACER E.H.M.	LDS DFTSMAN G.H.F.
CHECKER E.H.M.	C.O.	CHIEF DFTSMAN S.A. S.O.

SUBMITTED:

Walter Burton
 COL., ORD. DEPT.

APPROVED BY ORDER OF C. OF O.

John D. Hill
 COL., ORD. DEPT., U.S.A.

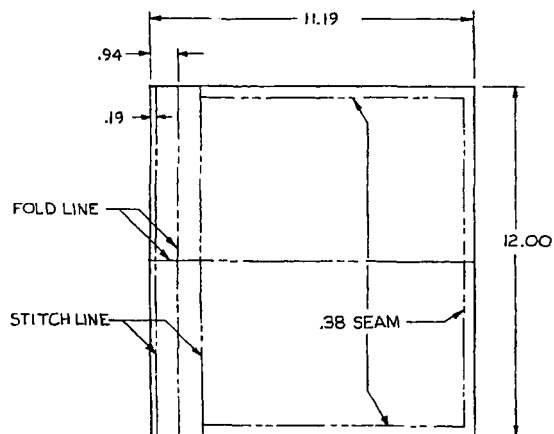
ORDNANCE DEPARTMENT, U.S.A.

SUPERSEDES A153116

A5153116

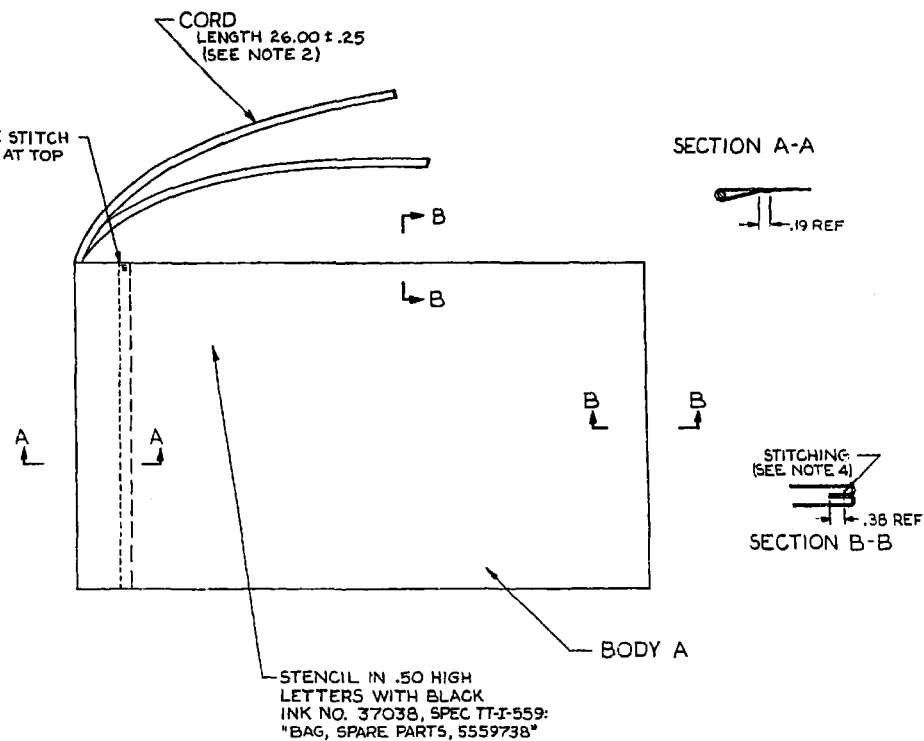
NOTE:

1. CLOTH, NYLON, TYPE II, CLASS I OR 2, OLIVE DRAB NO. 34052 THRU 34102 OF FED-STD-595, SPEC MIL-C-20696.
2. CORD, NYLON, TYPE I, SPEC MIL-C-7515.
3. THREAD, POLYESTER, TYPE I OR II, SIZE FF, OLIVE DRAB, (SHADE 5-1) SPEC V-T-285.
4. MACHINE STITCH WITH LOCKSTITCH TYPE 301 FED-STD-751, SEAM AND STITCHING TYPES PER FED-STD-751, 6 TO 8 STITCHES PER INCH, BACKSTITCH .50 INCH MINIMUM.
5. MANUFACTURE IN ACCORDANCE WITH MIL-C-10632.



BODY A
(SEE NOTE 1)
SCALE 1/2

NOTE: TRIPLE STITCH
SIDE SEAM AT TOP
OF BAG.



STENCIL IN .50 HIGH
LETTERS WITH BLACK
INK NO. 37038, SPEC TT-T-559:
"BAG, SPARE PARTS, 5559738"

PART NO. 5559738

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING JUN 1, 1934		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TP		YIELD STRENGTH	30,000	DESIGN	RVR	REM	BAG, SPARE PARTS
TS	A12002939	TENSILE	30,000	MATERIAL	SEE NOTE 1, 2 & 3		
EL	A12001930	ELONGATION	10%	HEAT TREATMENT			
RA	M1918A2	APPROVED		SUBMITTED			
RM	LOE 7142391	REVIEWED		APPROVED	HAROLD A. CARLSON		D 19204 5559738
RM	M1917A1	USED WITH		APPROVED	WALTER ACKERMAN		
APPLICATION		FINAL PROTECTIVE FINISH		SCALE 1/1		SHEET 1 OF 1	

LINE NO.	LIST OF SPECIFICATIONS	SPEC NUMBER	REVISION		LINE NO.	DRAWING NUMBER	PART NUMBER	LIST OF PARTS	MATL	MATL SPEC	UNIT WT	QTY PER UNIT ASSY
			SYM	DATE								
1	FINISHES, PROTECTIVE FOR IRON & STEEL PARTS	57-0-2			1	C5564183	5564183	ROD, CLEANING, SUB MACHINE GUN				38
2	GENERAL SPECIFICATION GOVERNING THE				2	A5152734	5152734	HEAD, CLEANING ROD	FS 1018, FS 1022	QQ-S-633	05	1
3	MANUFACTURE & INSPECTION OF SMALL				3	BFDXI	505471	PIN, STRAIGHT, $\frac{3}{8} \times \frac{1}{8}$	DR ROD	57-108		1
4	ARMS WEAPONS, SPARE & REPLACEMENT				4	C5564184	5564184	ROD, CLEANING	FS 1018, FS 1022	QQ-S-633	33	1
5	PARTS AND ACCESSORIES	52-0-1			5							
6	METALS, GENERAL SPECIFICATION FOR											
7	INSPECTION OF	QQ-M-151										
8	STEEL, CARBON, BARS (GENERAL PURPOSE)	QQ-S-633										
9	TOOL STEEL, CARBON & ALLOY	57-108										
10	WELDING OF STEEL, METAL ARC	57-206-1										
11												
12												
13												
LINE NO.	LIST OF DRAWINGS	DRAWING NUMBER	REVISION									
			SYM	DATE								
1	ROD, CLEANING, SUB MACHINE GUN	C5564183										
2		C5564184										
3		A5152734										
4		BFDXI										
5												
6												
7	MANUFACTURER'S IDENTIFICATION SYMBOLS	B7122847										

NOTE:
SPECIFICATIONS FOR PACKAGING & MARKING
OF SHIPMENTS AND/OR INSTRUCTIONS SHOULD
APPEAR IN THE CONTRACT.

0 1 2 IN.

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS		MATERIAL		HEAT TREATMENT		FINAL PROTECTIVE FINISH	
TEMP		AS BUILT		45 SMC-MN-A1					
TS									
FLT									
SA									
SH									
DI									

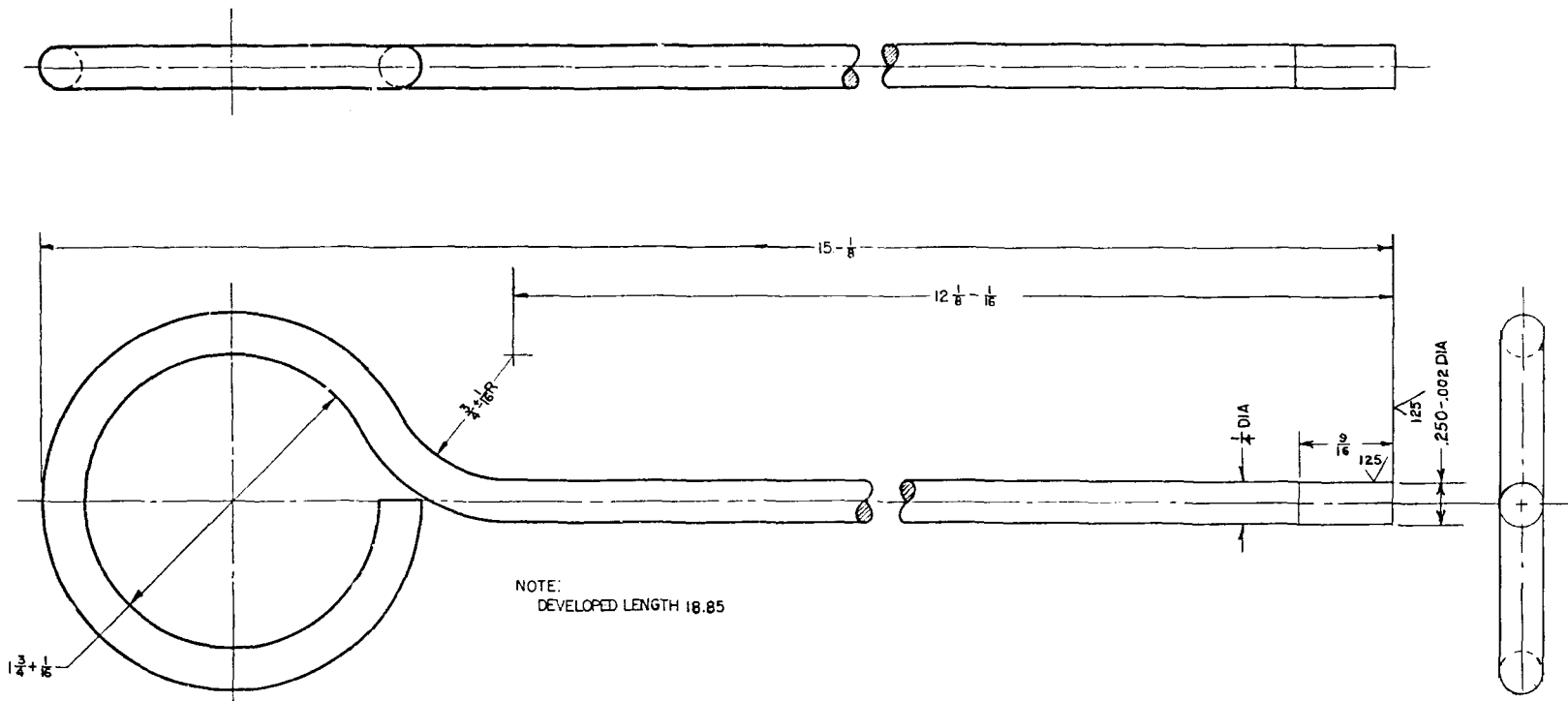
APPLICATION		DO		NO	
APPLY					

ORIGINAL DATE		OF DRAWING		DRAFTSMAN		CHECKER		ENGINEER		SUBMITTED		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		SCALE GRAPHIC		UNIT WT. 38	
DEC 10, 1937		GAF	LSC	CHK	CS	ENG											

REVISIONS		DATE		APPROVAL	
8	WAS C64183	12-8-30			

ORDNANCE DEPT		DEPT OF THE ARMY		ROCK ISLAND ARSENAL	
PART NO. 5564183		SHOWING REVISIONS IN EFFECT ON		C 5564183	

C5564183



PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES	
TP		TOLERANCES ON	DECIMALS
TS		ANGLES	FRACTIONS $\pm 1/64$
EL 2		MATERIAL	STEEL FS 1018, FS 1022
RA	C5564183	HEAT TREATMENT	SPEC QQ-S-633
BN		HEAT ASSEY	USED ON
RM		APPLICATION	DO NOT APPLY PART NO
		DO	NO SPECIFIC

ORIGINAL DATE	DEC 10, 1937
OF DRAWING	
TRACER	GAF
ENGINEER	LSC
INSPECTOR	ECW
SUBMITTER	
APPROVED	
DATE	

PART NO. 5564184

SYN	REVISIONS	DATE
A	SEE ERR HGR 30732	25 SEP 73
3	WAS C64184	112-8-50

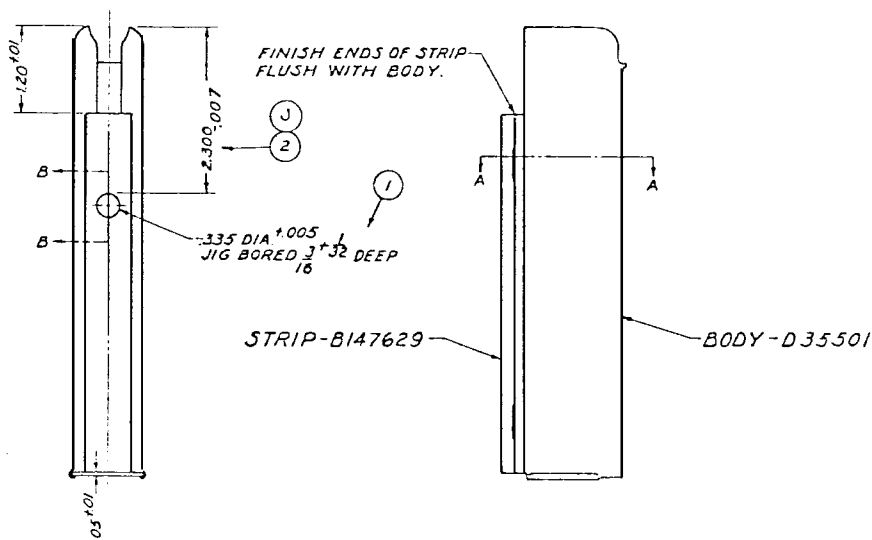
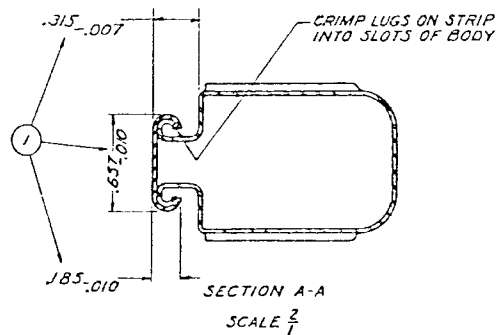
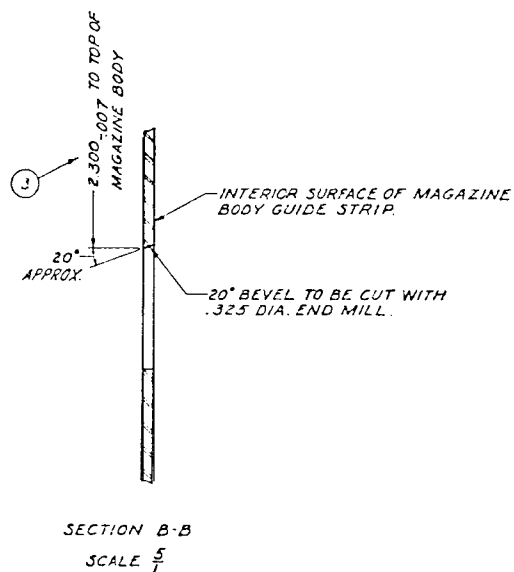
ROD, CLEANING

ORDNANCE DEPT
DEPT OF THE ARMY
ROCK ISLAND ARSENAL

DWG
SIZE
C 5564184

HEAT TREATMENT & FINAL FINISH

PENETRATE

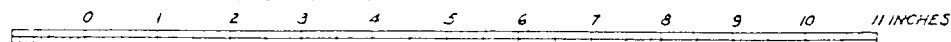


LIST OF COMPONENTS

LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	C 64349	TUBE, MAGAZINE, ASSEMBLY	1
2		COMPOSED OF:	
3	D35501	1- BODY, MAGAZINE	*
4	B147629	1- STRIP, MAGAZINE BODY GUIDE	*
5			
6			

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



PHYSICAL PROPERTIES	AUGUST 28, 1941 REVISIONS
1 P	1' 11-16-42
1 S	2' 10-15-43
EL 2	3' 11-23-43
KTD	4' 10-30-51
BR	
ROCK	
SCL	

DRG PERTAINS TO
D35500 MAGAZINE, BOX,
20 CARTRIDGE

TUBE, MAGAZINE, ASSEMBLY 5564349
(64349)

1 2 3

C5564349
REF. DRG. J.A. 15305

64349

SYMBOL
<p>WILLIAMS</p> <p>LT COL JRD DEPT USA</p> <p>CHIEF OF INSPRANCE</p> <p>ORDNANCE DEPT USA</p> <p>SUPERSEDES C64349</p>

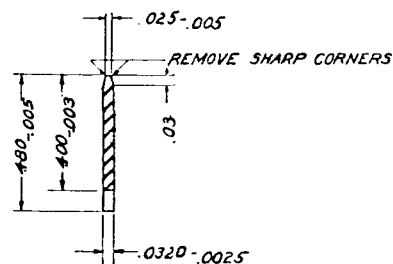
C5564349

HEAT TREATMENT & FINAL FINISH

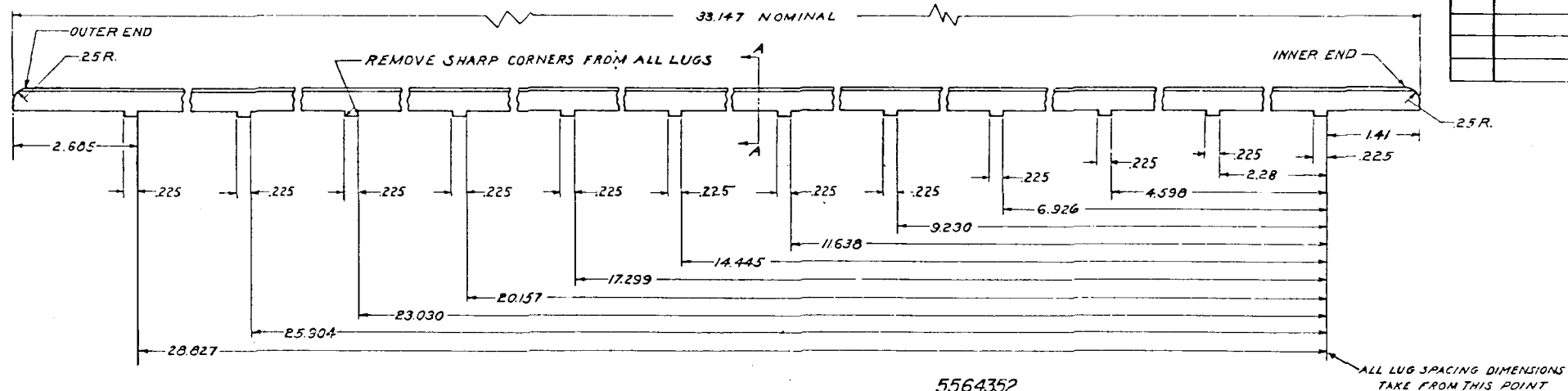
PHYSICAL PROPERTIES		OCTOBER 20, 1941 REVISIONS	
Y.P.		1	10-30-51
T.S.			
EL 2			
RED			
BR.			
ROCK. 8-92			
SCL.			

DRG PERTAINS TO

035500	MAGAZINE DRUM, 50 CARTRIDGE
CG438	EDDY MAGAZINE ASSEMBLY



SECTION A-A
SCALE $\frac{4}{1}$



5564352
 (C-64352)
GUIDE, BODY
STEEL WD.10/0
FINISH "J"
 MANUFACTURING COMPONENT

TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 5Q038-3

SCALE 1/2
C5564J52 C-64J52

SYMBOL

DISPATCH	CLASS	DATE	PLAN
11/11/64	11/11/64	11/11/64	11/11/64
ENCLOSURE	11/11/64	11/11/64	11/11/64
11/11/64	11/11/64	11/11/64	11/11/64

SUBMITTED

11/11/64

LT. COL. J. R. ...

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

John ...

ORDNANCE DEPT USA

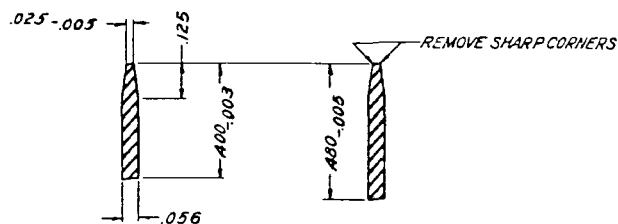
SUPERSEDES C64352

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES		OCTOBER 20, 1941	
		REVISIONS	
Y.P.		1	10-30-37
T.S.			
EL. 2			
RED			
BR.			
ROCK.	B 90-93		
SCL.			

DRG PERTAINS TO

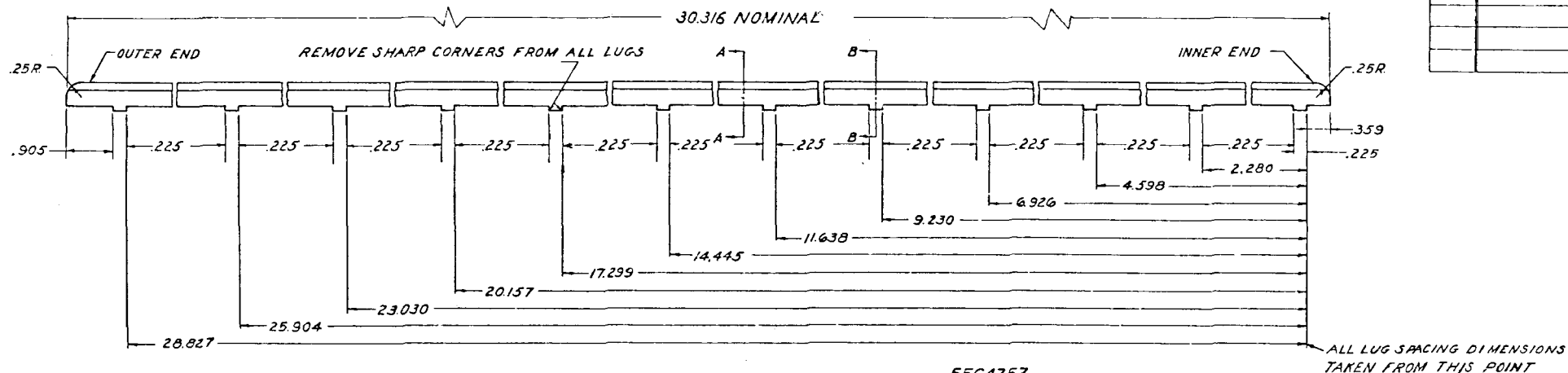
035503 MAGAZINE DRUM,
100 CALIBRE
CG4360 COVER MAGAZINE,
ASSEMBLY



SECTION A-A

SECTION B-B

SCALE $\frac{4}{1}$



5564353
GUIDE, COVER 664353
STEEL-WD1010
FINISH
MANUFACTURING COMPONENT

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE $\frac{1}{1}$
C5564353

REF. UNITED SPECIALTIES
COMPANY, DRG. NO. 50015

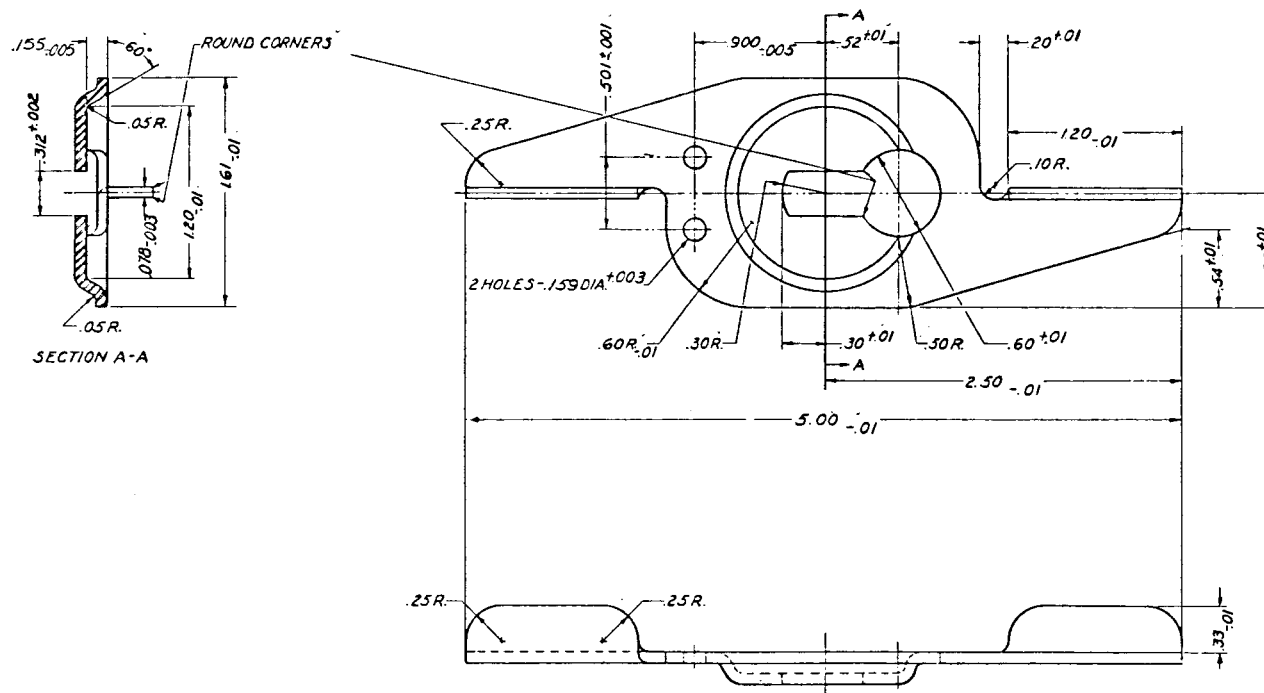
664353

SYMBOL	
DATE	10-30-37
BY	J. H. B. / J. H. B.
CHKD	J. H. B. / J. H. B.
APP'D	J. H. B. / J. H. B.
SUBMITTED	J. H. B. / J. H. B.
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	
J. H. B. / J. H. B.	
ORDNANCE DEPT. U.S.A.	

SUPERSEDES C64353

C5564353

HEAT TREATMENT & FINAL FINISH	

[illegible][illegible]

KEY WINDING (C-64354 5564354
STEEL-W.D.1010
FINISH
MANUFACTURING COMPONENT

TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 50,008

C5564354 SCALE $\frac{2}{1}$

C-6-354

SYMBOL

NATSIAN TRACED LDB-1
N A S E I G N
CHECKER [Signature] 10/10/68
SUBMITTER [Signature]
[Handwritten signature]
LT COL 192 DEPT 1-2
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE -
[Signature]
COL ORG DEPT U.S.A.
ORDNANCE DEPT U.S.A.

SUPERSEDES C64354

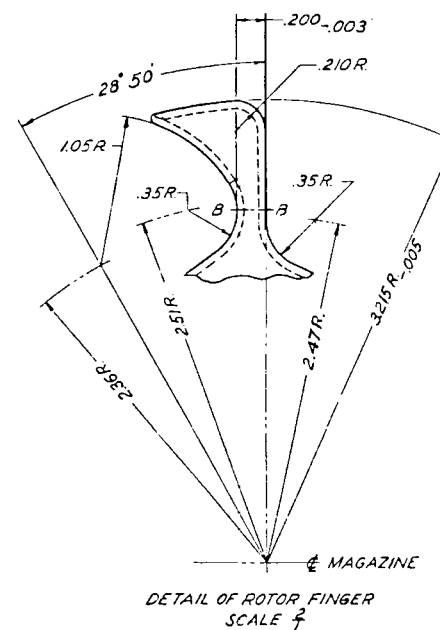
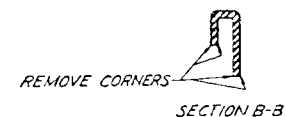
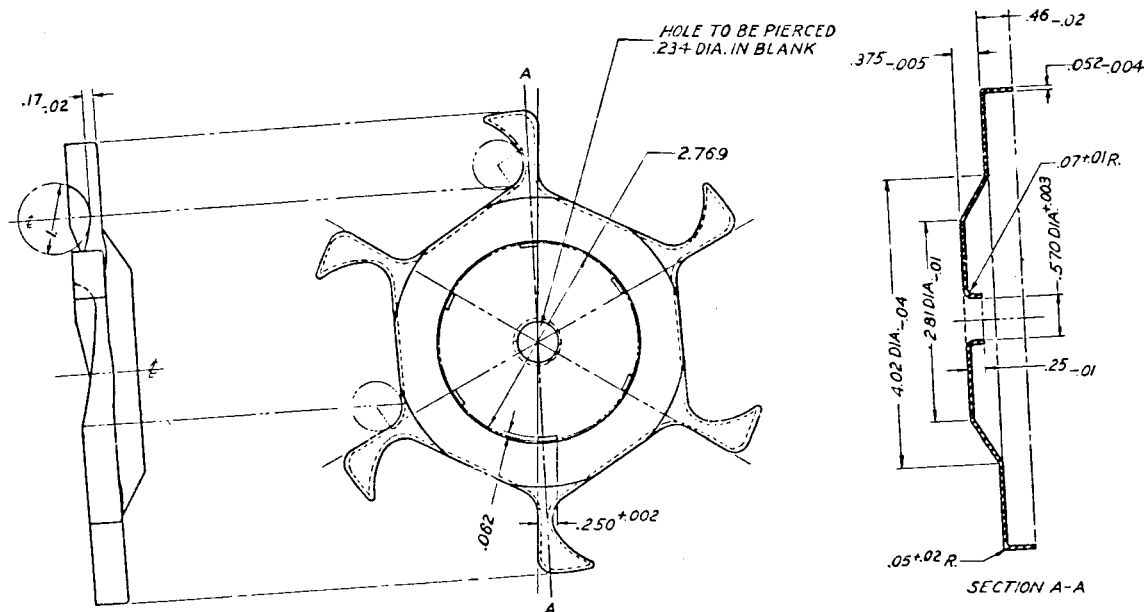
HEAT TREATMENT & FINAL FINISH
ANNEAL AFTER BLANKING.

PENTRATE

PHYSICAL PROPERTIES		OCTOBER 20, 1941	
		REVISIONS	
Y.P.		1	10-30-51
T.S.			
EL. 2			
RED			
B.R.			
ROCK. B-34-41			
SCL.			

DRG PERTAINS TO

035505 MAGAZINE, ORIGIN.
50 CARTRIDGE
035504 ROTOR ASSEMBLY



ROTOR (C64355-5564355)
STEEL-WD. 1010
FINISH F
MANUFACTURING COMPONENT

TOLERANCE * ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

C5564355

SCALE 7/8

REF: UNITED AIR CLEANER CO. DRG. NO. 50,033

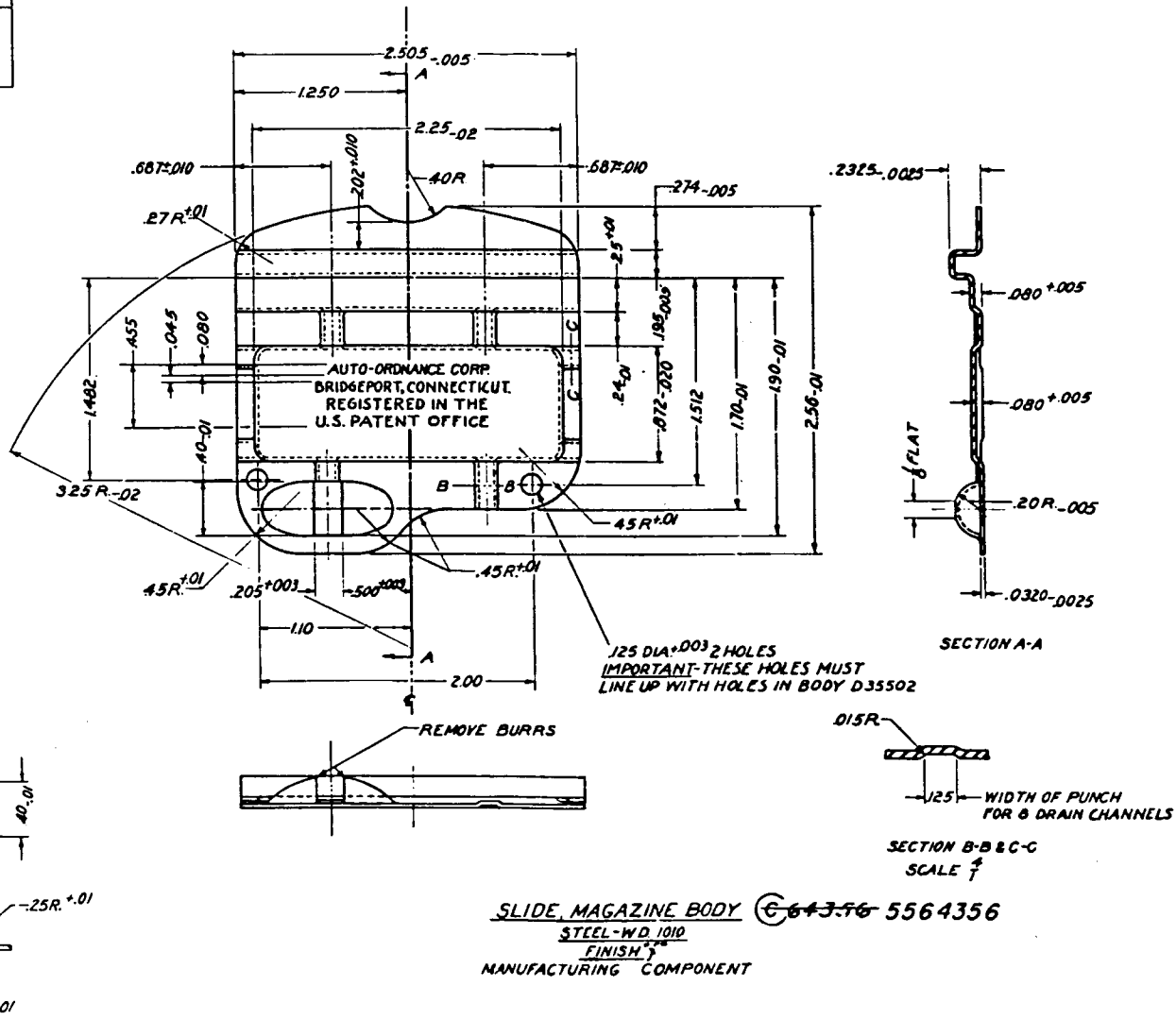
C64355

SYMBOL	
DESIGNED	TRACED
BY	BY
CHECKED	BY
SUBMITTED	BY
APPROVED BY: J. E. G. M.	
J. E. G. M.	
ORDNANCE DEPT. U.S.A.	

SUPERSEDES C64355

C5564355

HEAT TREATMENT & FINAL FINISH



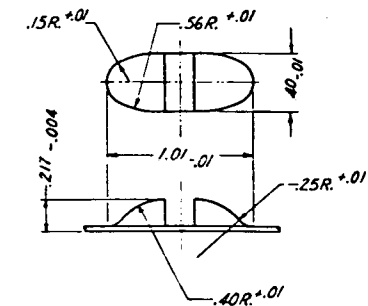
SLIDE MAGAZINE BODY © 64376 5564356
STEEL-WD 1010
FINISH
MANUFACTURING COMPONENT

PHYSICAL PROPERTIES		OCTOBER 20, 1941	
		REVISIONS	
Y.P.		1	10-26-31
T.S.			
EL. 2			
RED			
BR.			
ROCK. B43-45			
SCL.			

DRG PERTAINS TO
D35502 MAGAZINE DRUM
D35503 CARTRIDGE
C64356 BODY MAGAZINE
SLIDE ASSEMBLY

SECTION A-A

SECTION B-B & C-C
SCALE 1/2"



VIEW SHOWING CONSTRUCTION OF FORMATION ON SURFACE OF SLIDE

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

C5564356

SCALE 1/2"

REFUNITED AIR CLEANER CO. DRG. NO. 50018

C-64356

SYMBOL	
DESIGNED BY	W. J. B. 10/26/41
CHECKED BY	W. J. B. 10/26/41
APPROVED BY	W. J. B. 10/26/41
SUBMITTED BY	W. J. B. 10/26/41
BY ORDER OF THE	LT COL. ORD. DEPT. U.S.A.
SIGNED	W. J. B. 10/26/41
ORDNANCE DEPT. U.S.A.	

SUPERSEDES C64356

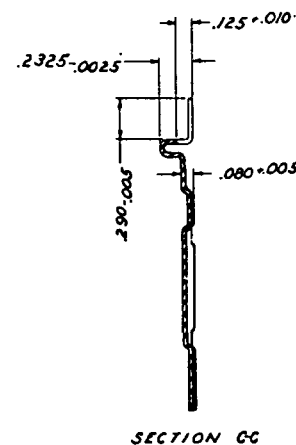
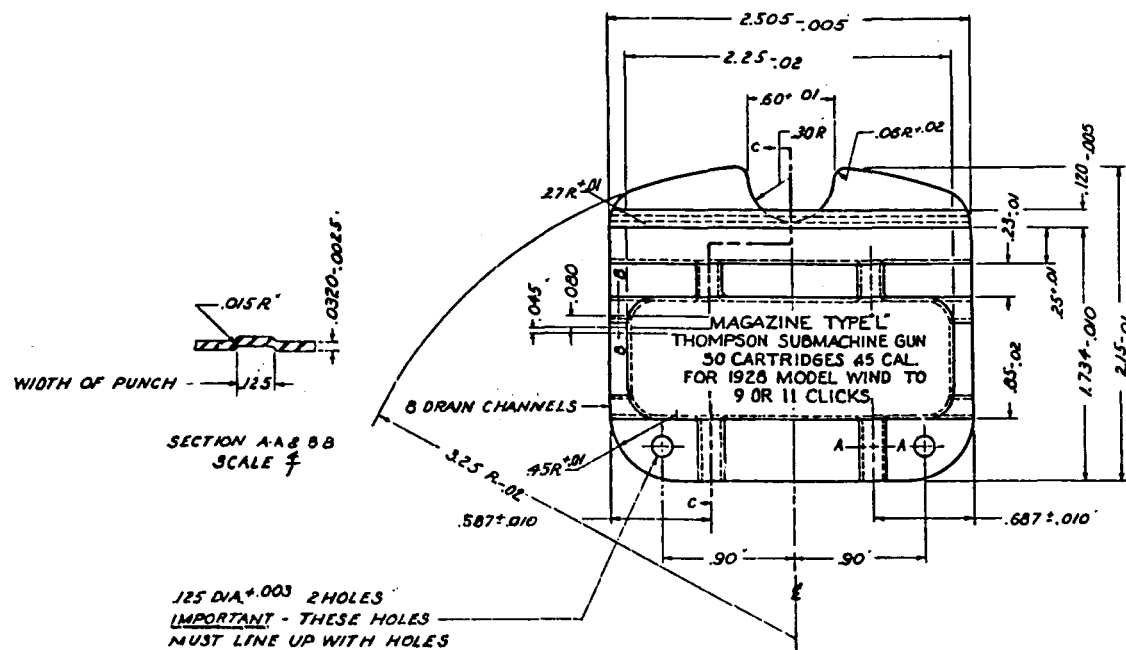
C5564356

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES		OCTOBER 20, 1941	
		REVISIONS	
Y.P.		/	
T.S.			
EL.2			
RED.			
BR.			
ROCK.	B-1345		

DRG. PERTAINS TO

D35505 MAGAZINE, DRUM
50 CARTRIDGE
COVER, MAGAZINE
W/SLIDE, ASSEMBLY



1/25 DIA ± .003 2 HOLES
IMPORTANT - THESE HOLES
MUST LINE UP WITH HOLES
IN COVER, D35505

SLIDE, MAGAZINE COVER (C-64357-5564357)
STEEL - WD. 1010
FINISH - S
MANUFACTURING COMPONENT

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

C5564357 SCALE 7/8

REF. DRG. UNITED AIR
CLEANER CO. 50031

C-64357

DESIGNED A. M.	DRAWN A. M.	CHECKED A. M.
ENGINEER G. H.	MANUFACTURED EGW	APPROVED EGW
SUBMITTED		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
10 FEB. ORG. DEPT. U. S. A.		
10 FEB. ORG. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

SHIPPER'S REF. C64357

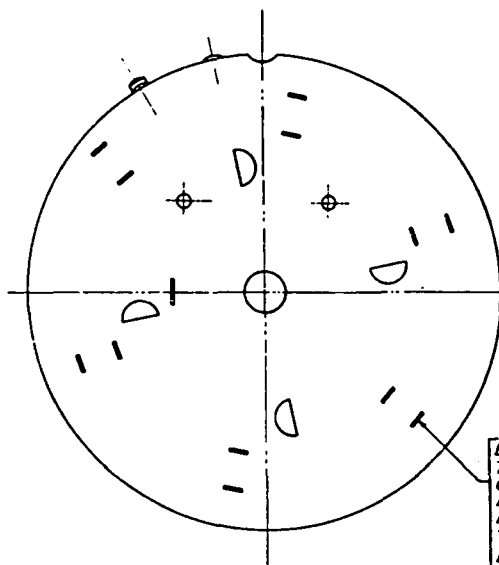
C5564357

HEAT TREATMENT & FINAL FINISH

Y.P.
T.S.
EL. 2
RED
BR.
POCK.
SCL.

[illegible]

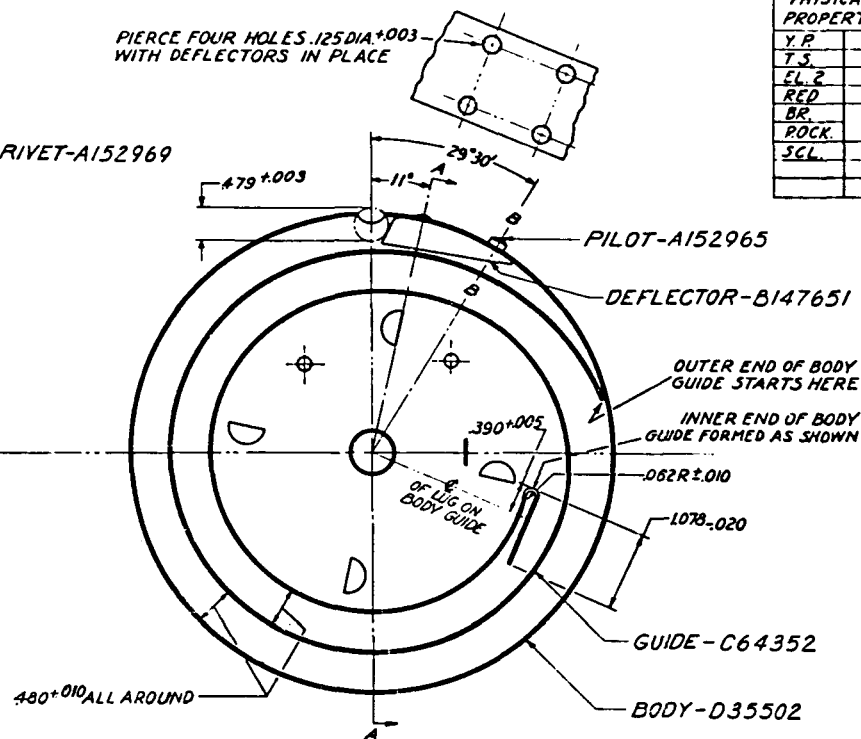
D35508	MAGAZINE DRUM
	50 CARTRIDGE
C64359	BODY, MAGAZINE
	W/SLIDE ASSEMBLY

[illegible]

BODYGUIDE RIVETED TO BODY. RIVET SECURELY WITH GOOD HEAD AND STAKE. FLATTEN STAKING TO REMOVE SHARP EDGES.



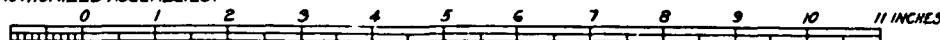
SECTION A-A



LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	QTY REQUIRED PER UNIT ASM
1	C64358	BODY, MAGAZINE, ASSEMBLY	*
2		COMPOSED OF:-	(1)
3	D35502	1-BODY, MAGAZINE	*
4	B147651	2-DEFLECTOR, CARTRIDGE	*
5	C64352	1-GUIDE, BODY	*
6	A152965	1-PILOT, COVER	*
7	A152969	3-RIVET, CARTRIDGE DEFLECTOR	
8			
9			

BODY, MAGAZINE, ASSEMBLY ~~(664358~~ 5564358
MANUFACTURING ASSEMBLY

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



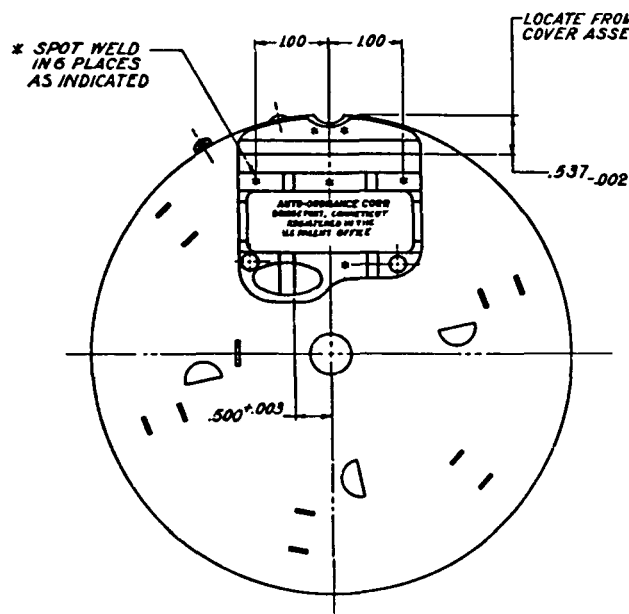
REF: UNITED AIR CLEAN
ER CO. DRG NO. 50,028

C-64358

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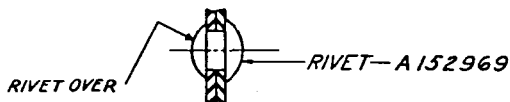
SUPERSEDES C64358

PENITRATE



LOCATE FROM BODY WITH
COVER ASSEMBLED THERETO

-SLIDE- C 64356



SECTION A-A
SCALE $\frac{4}{7}$

DEFLECTOR-B/47651

RIVET-A152969

—PILOT—A 152965

-GUIDE- C 64352

-BODY- 035502

PHYSICAL PROPERTIES		OCTOBER 20, 1941 REVISIONS	
Y.P.		1	10-30-51
T.S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

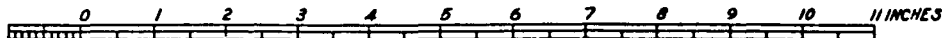
DRG PERTAINS TO

235525	MAGAZINE, DRUM, 50 CARTRIDGE
--------	---------------------------------

LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	C 64359	BODY, MAGAZINE, W/SLIDE, ASSEMBLY	(1)
2		COMPOSED OF:-	
3	C64350	1-BODY, MAGAZINE, ASSEMBLY	*
4	A152969	2-RIVET, MAGAZINE BODY SLIDE	*
5	C64356	1-SLIDE, MAGAZINE BODY	*
6			
7			

TOLERANCE IS ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

BODY, MAGAZINE, W/SLIDE, ASSEMBLY ~~(C-64359)~~ 5564359



C5564359

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 5Q026

~~C-64359~~

SYMBOL	
1	1
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98	98
99	99
100	100

PTJMAN	TRACER	1008 PTJMAN
N2M	430	6.1.E
CHIEF	EGW	CHIEF
TO N		
SUBMITTED -		

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE.

COB ORD DEPT. U.S.A.
ORDNANCE DEPT. U.S.A.

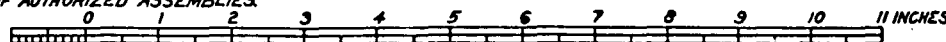
SUPERSEDES C64359

C5564359

[illegible]

COVER GUIDE RIVETED
TO COVER. RIVET SE-
CURELY WITH GOOD
HEAD AND STAKE.
FLATTEN STAKING
TO REMOVE SHARP
EDGES

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.
TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



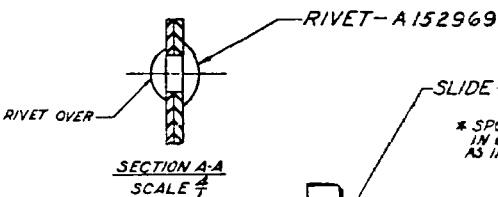
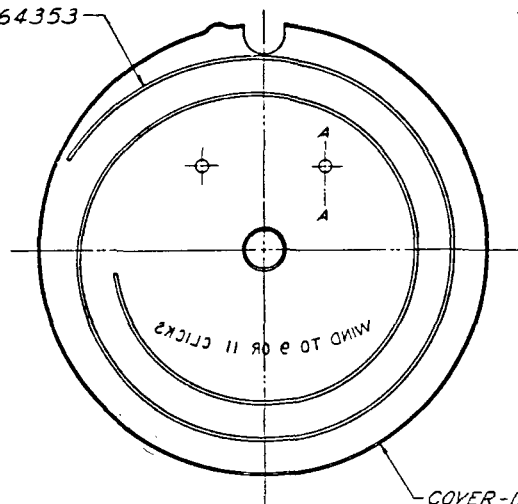
~~C-64360~~

SYMBOL			
ATTN: SAC	IN: 100	NO: 001	DATE: 10-1-64
FROM: SAC	TO: SAC	INFO: SAC	RE: SAC
SUBMITTED:			
J. Edgar Hoover			
LTCOL ORD DEPT USA			
APPROVED BY ORDER OF THE			
CHIEF OF ORDNANCE:			
J. Edgar Hoover			
LTCOL ORD DEPT USA			
ORDNANCE DEPT USA			

8105035050 261364

HEAT TREATMENT & FINAL FINISH
SAND BLAST AFTER ASSEMBLING BODY
AND COVER - COLOR SEPARATELY
PENTRATE

GUIDE - C64353

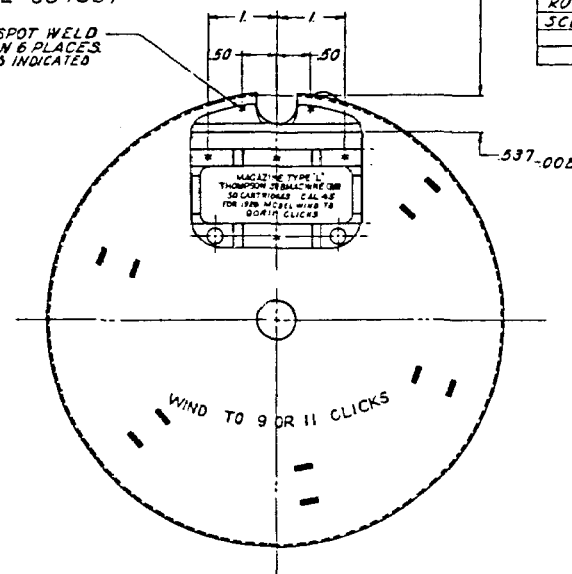


RIVET - A152969

SLIDE - C64357

* SPOT WELD
IN 6 PLACES
AS INDICATED

LOCATE FROM BODY
ASSEMBLED TO COVER



PHYSICAL PROPERTIES	OCTOBER 20, 1941
Y.P.	10-30-31
T.S.	
EL. 2	
RED	
BR.	
ROCK.	
SCL.	

DRG PERTAINS TO

D35503 MAGAZINE DRUM
50 CARTRIDGE

C5564361

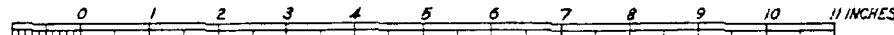
LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	C64361	COVER, MAGAZINE, W/SLIDE, ASSEMBLY	(1)
2		COMPOSED OF -	
3	C64360	1-COVER, MAGAZINE, ASSEMBLY	*
4	A152969	2-RIVET, MAGAZINE COVER SLIDE	*
5	C64357	1-SLIDE, MAGAZINE COVER	*
6			
7			

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES

TOLERANCES * ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED

COVER, MAGAZINE, W/ SLIDE, ASSEMBLY C64361 5564361



C5564361

REF. UNITED AIR
CLEANER CO. DRG. 50027

C64361

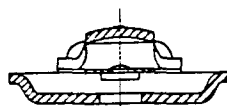
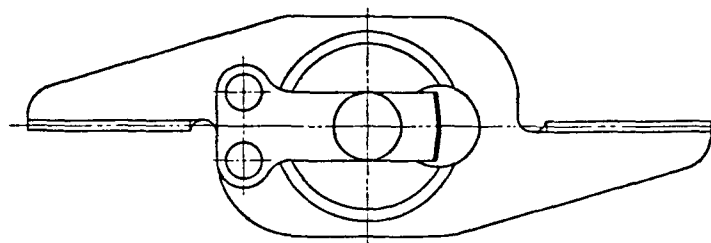
SYMBOL
<p>REVISIONS</p> <p>1. 10-30-31</p> <p>2. 10-30-31</p> <p>3. 10-30-31</p> <p>4. 10-30-31</p> <p>5. 10-30-31</p> <p>6. 10-30-31</p> <p>7. 10-30-31</p> <p>8. 10-30-31</p> <p>9. 10-30-31</p> <p>10. 10-30-31</p> <p>11. 10-30-31</p> <p>12. 10-30-31</p> <p>13. 10-30-31</p> <p>14. 10-30-31</p> <p>15. 10-30-31</p> <p>16. 10-30-31</p> <p>17. 10-30-31</p> <p>18. 10-30-31</p> <p>19. 10-30-31</p> <p>20. 10-30-31</p> <p>21. 10-30-31</p> <p>22. 10-30-31</p> <p>23. 10-30-31</p> <p>24. 10-30-31</p> <p>25. 10-30-31</p> <p>26. 10-30-31</p> <p>27. 10-30-31</p> <p>28. 10-30-31</p> <p>29. 10-30-31</p> <p>30. 10-30-31</p> <p>31. 10-30-31</p> <p>32. 10-30-31</p> <p>33. 10-30-31</p> <p>34. 10-30-31</p> <p>35. 10-30-31</p> <p>36. 10-30-31</p> <p>37. 10-30-31</p> <p>38. 10-30-31</p> <p>39. 10-30-31</p> <p>40. 10-30-31</p> <p>41. 10-30-31</p> <p>42. 10-30-31</p> <p>43. 10-30-31</p> <p>44. 10-30-31</p> <p>45. 10-30-31</p> <p>46. 10-30-31</p> <p>47. 10-30-31</p> <p>48. 10-30-31</p> <p>49. 10-30-31</p> <p>50. 10-30-31</p> <p>51. 10-30-31</p> <p>52. 10-30-31</p> <p>53. 10-30-31</p> <p>54. 10-30-31</p> <p>55. 10-30-31</p> <p>56. 10-30-31</p> <p>57. 10-30-31</p> <p>58. 10-30-31</p> <p>59. 10-30-31</p> <p>60. 10-30-31</p> <p>61. 10-30-31</p> <p>62. 10-30-31</p> <p>63. 10-30-31</p> <p>64. 10-30-31</p> <p>65. 10-30-31</p> <p>66. 10-30-31</p> <p>67. 10-30-31</p> <p>68. 10-30-31</p> <p>69. 10-30-31</p> <p>70. 10-30-31</p> <p>71. 10-30-31</p> <p>72. 10-30-31</p> <p>73. 10-30-31</p> <p>74. 10-30-31</p> <p>75. 10-30-31</p> <p>76. 10-30-31</p> <p>77. 10-30-31</p> <p>78. 10-30-31</p> <p>79. 10-30-31</p> <p>80. 10-30-31</p> <p>81. 10-30-31</p> <p>82. 10-30-31</p> <p>83. 10-30-31</p> <p>84. 10-30-31</p> <p>85. 10-30-31</p> <p>86. 10-30-31</p> <p>87. 10-30-31</p> <p>88. 10-30-31</p> <p>89. 10-30-31</p> <p>90. 10-30-31</p> <p>91. 10-30-31</p> <p>92. 10-30-31</p> <p>93. 10-30-31</p> <p>94. 10-30-31</p> <p>95. 10-30-31</p> <p>96. 10-30-31</p> <p>97. 10-30-31</p> <p>98. 10-30-31</p> <p>99. 10-30-31</p> <p>100. 10-30-31</p>

SUPERSEDES C64361

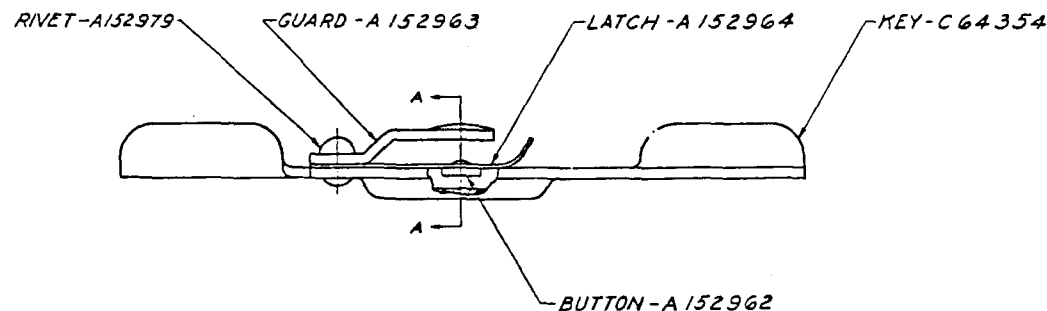
SAND BLAST
&
PENTRATE

PHYSICAL PROPERTIES		OCTOBER 20, 1941 REVISIONS	
Y.P.		1	CONVERSION 10-30-51
T.S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

D3523	MAGAZINE, DRUM, 50 CARTRIDGE.
-------	----------------------------------



SECTION A-A

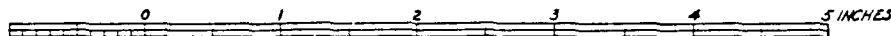


LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	C 64362	KEY, WINDING, ASSEMBLY	1
2		COMPOSED OF :-	
3	A152963	1-GUARD, WINDING KEY LATCH	*
4	C 64354	1-KEY, WINDING	*
5	B147656	1-LATCH, WINDING KEY, ASSEMBLY	*
6	A152979	2-RIVET, LATCH GUARD	

KEY. WINDING. ASSEMBLY ~~C64362~~ 5564362

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



C5564362

REF: UNITED AIR CLEAN-
ER CO. ORG. NO. 50,022

C 64362

SYMBOL	DESCRIPTION
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
9	9
10	10
11	11
12	12
13	13
14	14
15	15
16	16
17	17
18	18
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86	86
87	87
88	88
89	89
90	90
91	91
92	92
93	93
94	94
95	95
96	96
97	97
98	98
99	99
100	100

DETSMAN N.Y.	TRACER N.Y.	LDG DETSMAN L.I.C.
CHUCKER C.T.	CHUCKER C.T.	CHIEF DETSMAN SA. M.T.

SUBMITTED:-
/ *W. L. D. S. S. S.*
LT. COL. J. D. DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

JOHN A. SMITH
JOA ORD DEPT U.S.A.
ORDNANCE DEPT USA

SUPERSEDES C64362

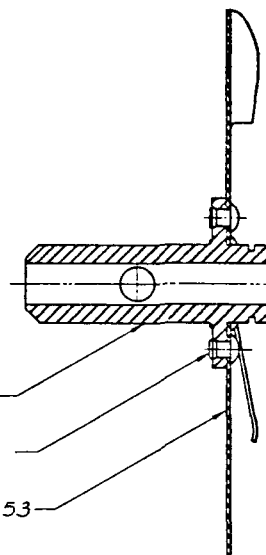
C5564362

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES		OCTOBER 20, 1941
		REVISIONS
Y.P.		1 CONVERSION 10-30-51
T.S.		
EL 2		
RED		
BR		
ROCK.		
SCL.		

DR'G PERTAINS TO	
D35505	MAGAZINE, DRUM. 50 CARTRIDGE
D35504	ROTOR, ASSEMBLY

D35508	MAGAZINE, DRUM, 50 CARTRIDGE
D35504	ROTOR, ASSEMBLY



RATCHET-B/47653

LIST OF COMPONENTS				
1	2	3	4	5
LINE NUMBER		NAME OF COMPONENT		NO REQUIRED PER UNIT ASM
1	664363	RATCHET, ASSEMBLY	*	(11)
2		COMPOSED OF:-		
3	0147652	1-HUB	*	
4	0147653	1-RATCHET	*	
5	4152970	6-RIVET, RATCHET	*	

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

RATCHET ASSEMBLY (C-64363-5564363)
MANUFACTURING ASSEMBLY

C5564363

REF UNITED AIR CLEAN-
ER CO. DRG NO. 50,023

SYMBOL

OFFSPMAMTRACER	LOG OFFSPMAM
✓	✓
CHECKED BY	CHECKED BY
✓	✓

SUBMITTED--

/ *James E. Smith*

LT COL. ORD DEPT U.S.A.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE--

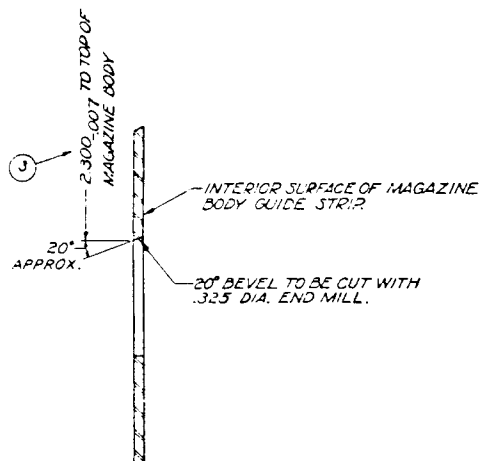
John E. Smith
COLORD DEPT U.S.A.

ORDNANCE DEPT U.S.A.

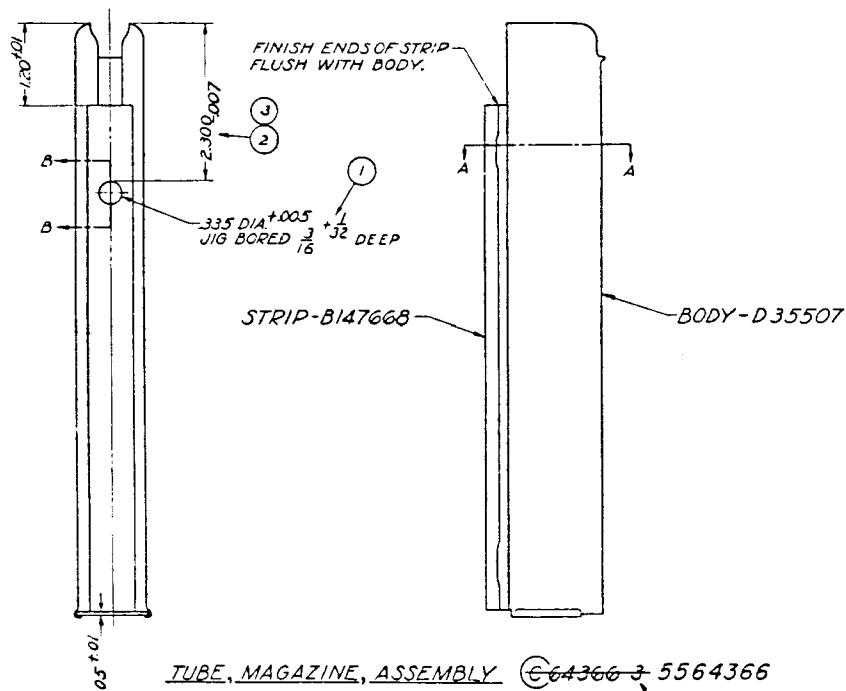
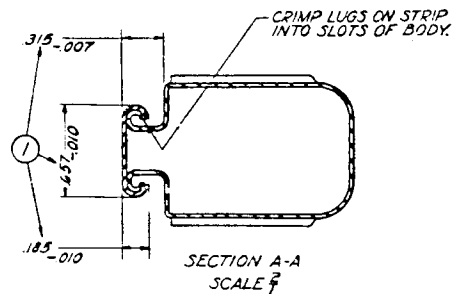
64363

SUPERSEDES C64363

PENTRATE



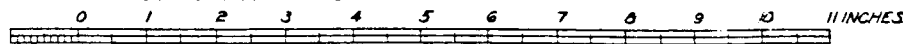
SECTION B-B
SCALE 5/



LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	ITEM NUMBER OR PIECE MARK	NAME OF COMPONENT	QUANTITY PER UNIT ASM
1	664366	TUBE, MAGAZINE, ASSEMBLY	1
2		COMPOSED OF:-	
3	D95507	1- BODY, MAGAZINE	*
4	3147663	1- STRIP, MAGAZINE BODY GUIDE	*
5			
6			

*WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



PHYSICAL PROPERTIES		DEC. 20, 1941 REVISIONS	
Y R		1 st 11-18-42	
T S		2 nd 10-15-43	
EL 2		3 rd 11-23-43	
RED		4 th 10-18-47	
BR			
ROCK			
SEL			

DRG PERTAINS TO	
Q35506	MAGAZINE, BOX,
	30 CARTRIDGE

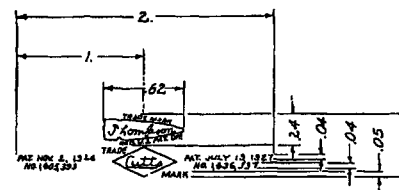
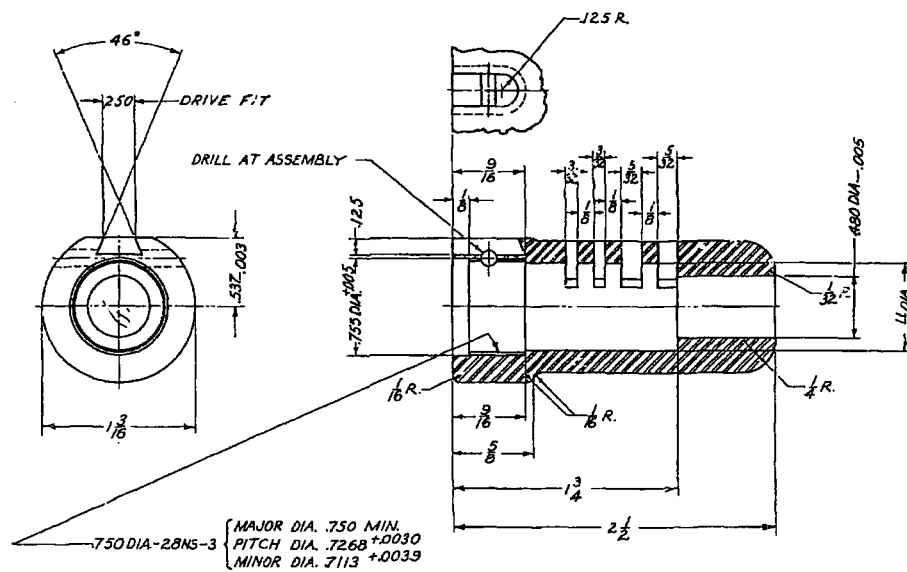
<u>SYMBOL</u>	
PT'S MANTOACER	LUG OF 10
WAVE	6 FT.
CORNER	SURF
999	24
JUGSIFIED	
moller Santa	
LT COL. ORD DEPT 41	
APPROVED BY ORDER OF THE	
CHIEF OF ORDNANCE:-	
M R W L Hume	
CAPT. ORD DEPT U.S.	
ORDNANCE DEPT U.S.	

C5564366
REF. DRG. S.A. 15305
~~C-64366~~

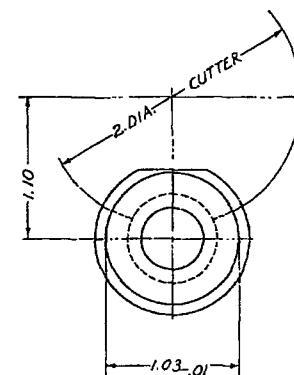
SUPERSEDES 664366

C5564366

HEAT TREATMENT & FINAL FINISH



DETAIL OF TRADE MARK IMPRESSION



COMPENSATOR RECOIL (C-64369 5564369
FINISH ⁵/₁₆"

TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

REF. ORG. A.O.C. (52)

C5564369

SCALE 2

C-64369

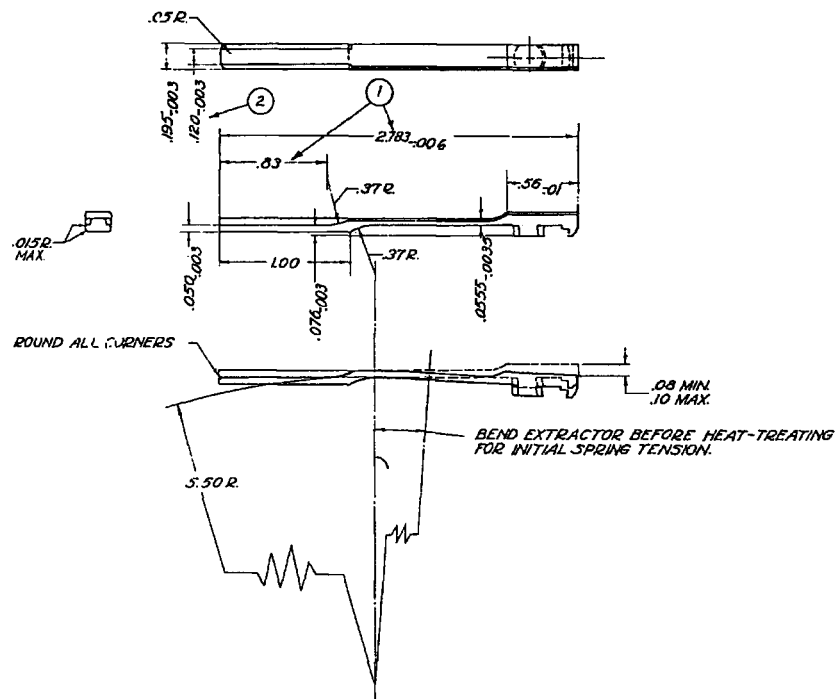
SUPERSEDES C64369

[illegible]

SYMBOL		
WITSMAN 688	TRACER 688	WIGGINTSMAN S 14
CHESNER C. M.	W. S.	CHEROTSON W. S. 1
SUBMITTED--		
<p>WILLIAMSON LT. COL. ORD. DEPT. U.S.A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE-- <i>John A. Smith</i> COL. ORD. DEPT. U.S.A. ORDNANCE DEPT. U.S.A.</p>		

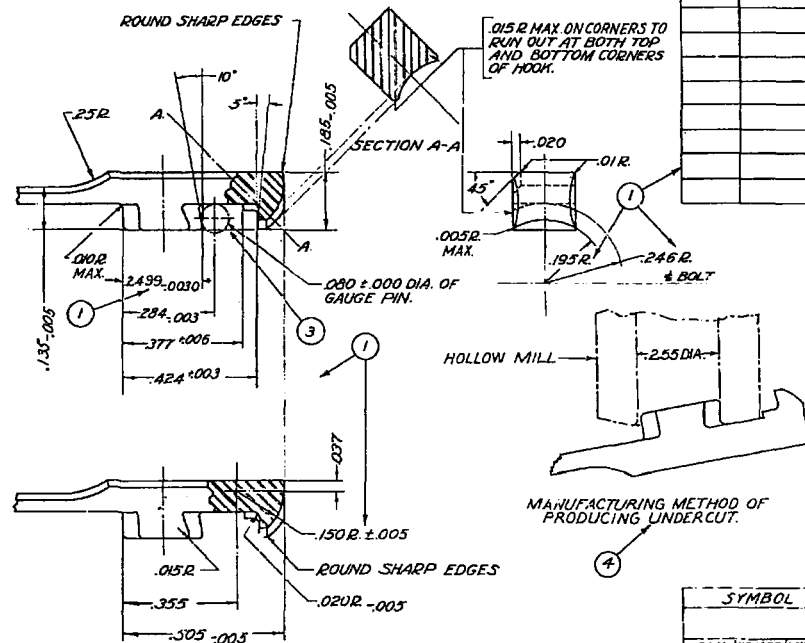
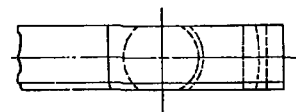
C5564369

HEAT TREATMENT & FINAL FINISH



EXTRACTOR 5564370-2
FINISH 1 2

TOLERANCE: ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



SCALE 7

SCALE 2

C5564370

REF. DRG. A.O.C. B42-10

6-64370

DEC. 31, 1941	
PHYSICAL PROPERTIES	REVISIONS
Y.P.	1 9-30-43
T.S.	2 10-9-43
EL. 2	3 12-30-43
RED	4 8-23-44
BR.	5 10-30-44
ROCK.	
SCL.	

DRG PERTAINS TO

51-63	A55MG-M20A1
51-116	A55MG-M1
51-124	A55MG-M1A1

SYMBOL

NOT TO SCALE
N.I.M. B.C.A. & A.P.
CHIEF OF BUREAU
SUBMITTED

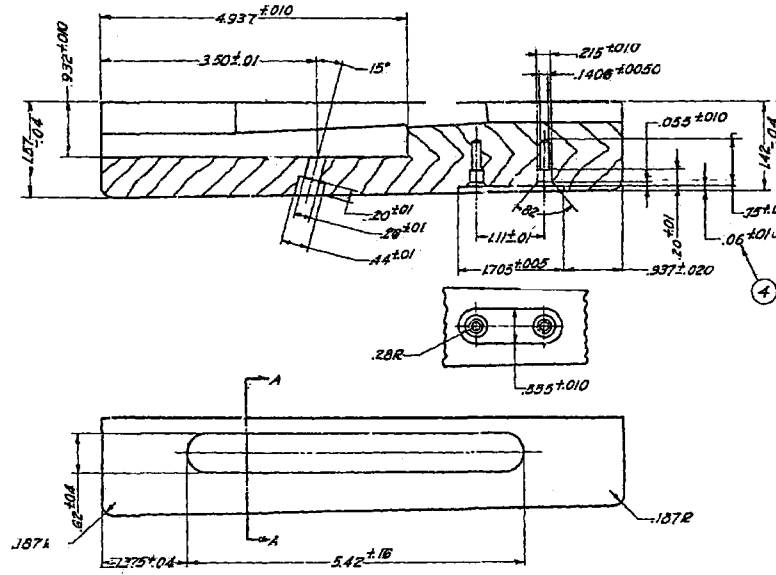
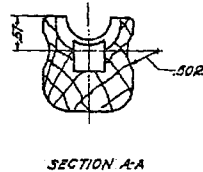
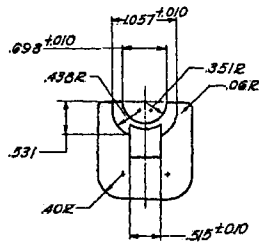
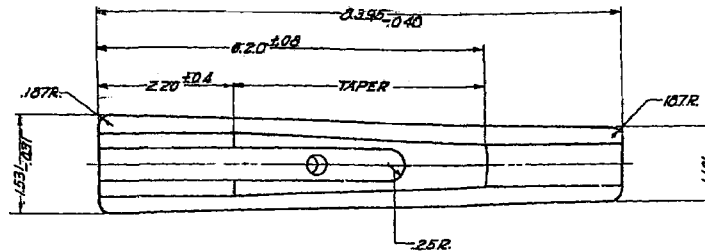
RECEIVED
DEC 1 1941
U.S. ARMY
HEADQUARTERS
WASHINGTON, D.C.

U.S. ARMY
HEADQUARTERS
WASHINGTON, D.C.

SUPPSEDES C64370

C5564370

HEAT TREATMENT & FINAL FINISH.



GRIP, FORE, HORIZONTAL (C64371) 5564371

TOLERANCE ± 0.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED

SUPERSEDES OLD TRACING C64371 UNDER REVISION DATE OF MAR. 3, 1943

PHYSICAL PROPERTIES		DEC 31, 1941	
		REVISIONS	
Y.P.		2	3-3-43
T.S.		3	12-30-43
EL.2		4	4-20-45
RED.		5	10-30-51
BR.			
ROCK.			

DRG. PERTAINS TO

51-116	45.3MG-M1
51-63	45.3MG-M28A1
51-124	45.3MG-M1A1
C64371	GRIP, FORE, HORIZONTAL, ASSY.

DESIGNED BY	TRACED BY	CHKD BY
CHECKED BY	APPROVED BY	DATE
SUBMITTED BY		
ONE INLAND DEPT. U.S.A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
ORDNANCE DEPT. U.S.A.		

REF. DRG. A.O.C. 842-142
SPRINGFIELD ARMORY

SCALE: 1/2

C5564371

C64371

SUPERSEDES C64371

C5564371

HEAT TREATMENT & FINAL FINISH

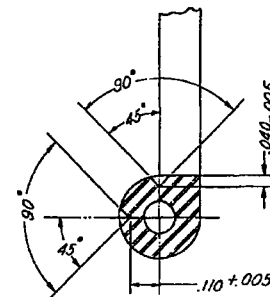
SIGHT GRADUATIONS			
RANGE	HEIGHT OF GRADUATIONS ABOVE ZERO.	RANGE	HEIGHT OF GRADUATIONS ABOVE ZERO
YARDS	INCHES	YARDS	INCHES
0	0	350	.575
50	.045	400	.700
100	.100	450	.830
150	.170	500	.965
200	.260	550	1.120
250	.350	600	1.280
300	.460		

[illegible]

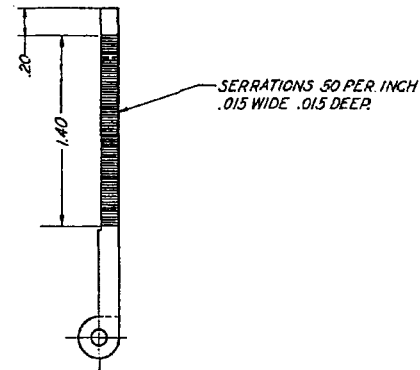
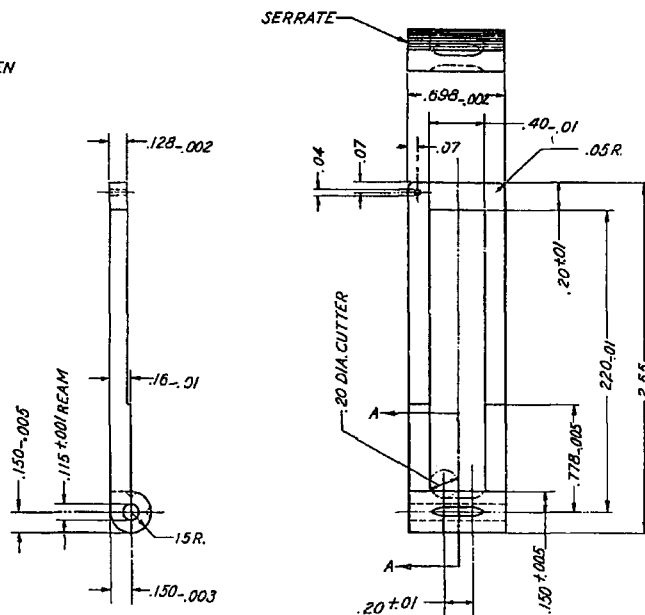
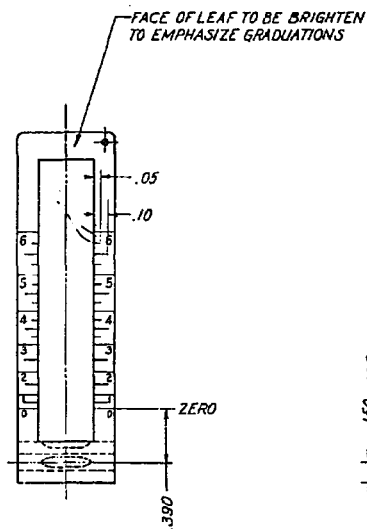
ORG PERTAINS TO

51-63	45SMG-M28A1
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C64382	LEAF, REAR SIGHTING
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SECTION - A A
SCALE $\frac{4}{1}$



LEAF, REAR, SIGHT (C-64373-5564373)
FINISH

TOLERANCE \pm . ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED

SYMBOL

OFFICER	TRACER	LD'S OFFICER
10	2.2.72	G. J. G.
CYCLER	10.6.72	CHIEF OFFICER
G. M.		10.6.72
SUBMITTED.		

SUBMITTED: *[Signature]*

LT. COLORD, DEPT U S A
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

W Moore
LT. COL. ORDN. PT. U.S.A.

ORDNANCE DEPT USA
SUPERSEDES C64373

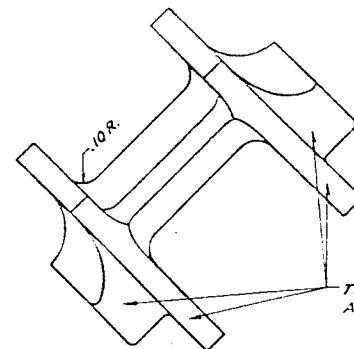
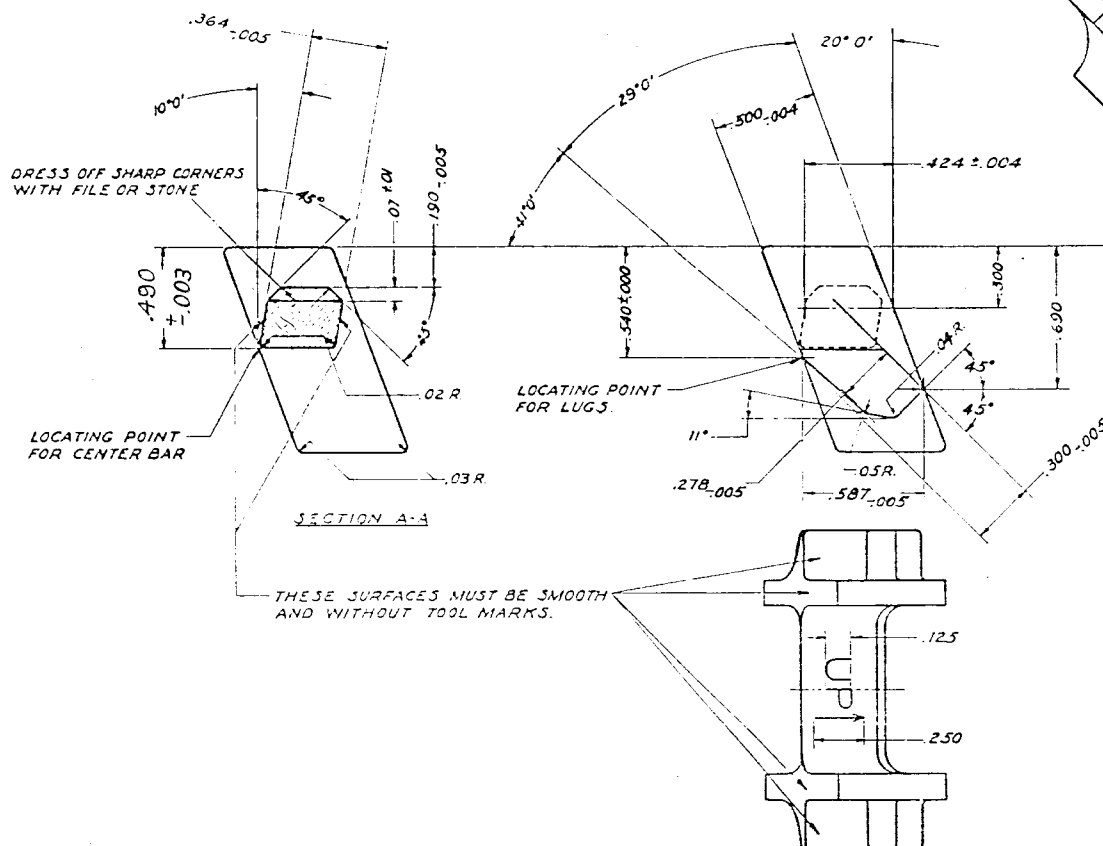
REF. DRG. A.Q.C. 45-7-2
C5564373 SCALE - $\frac{2}{1}$ ~~C64373~~

C5564373 SCALE-7 C64373

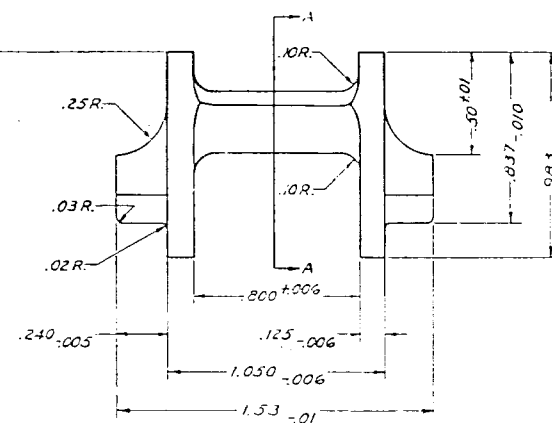
HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES	DEC. 31, 1941
TEMP.	
T.T.	
FL.	
RED.	
BR.	
ROCK.	

DRG. PERTAINS TO
51-63 155MG-M28A1



THESE SURFACES MUST BE SMOOTH AND WITHOUT TOOL MARKS.



LOCK FINISH 5564374
E-64374

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE 3/4

C5564374
REF. DRG. A.C.C. 45-G-3

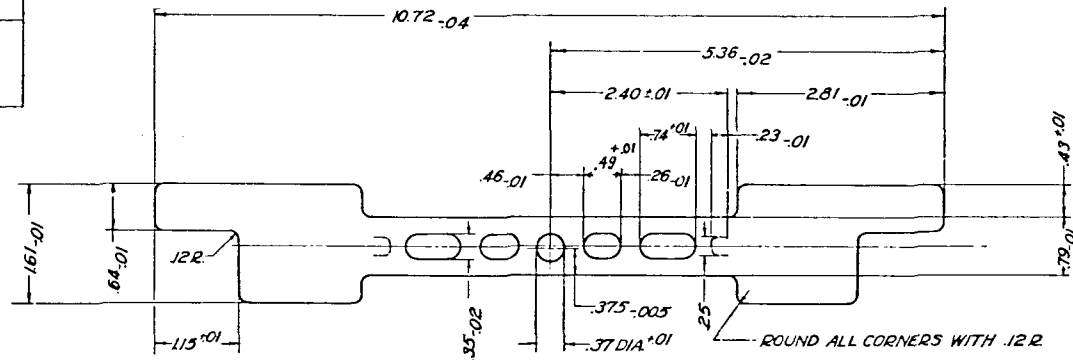
E-64374

DESIGNED	BY	DATE
6.1.1.1	6.1.1.1	6.1.1.1
CHECKED	BY	DATE
6.1.1.1	6.1.1.1	6.1.1.1
SUBMITTED	BY	DATE
6.1.1.1	6.1.1.1	6.1.1.1
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
6.1.1.1		
ORDNANCE DEPT. U. S. A.		

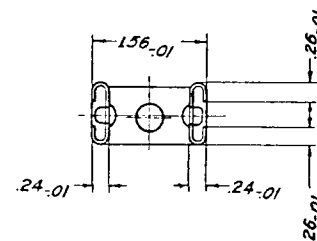
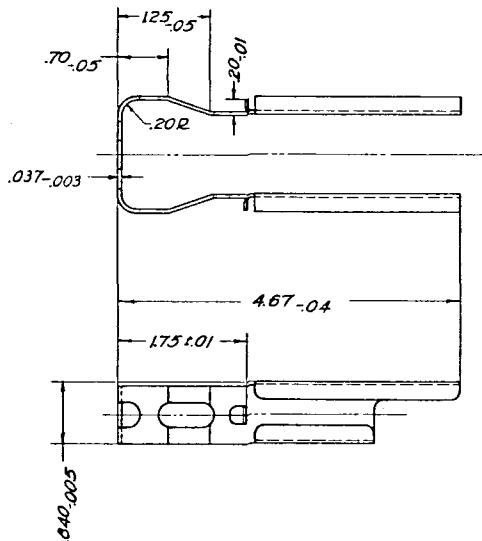
SUPERSEDES C64374

C5564374

HEAT TREATMENT & FINAL FINISH



DEVELOPMENT



OILER, BREECH C64375-5564375
FINISH "J"
MANUFACTURING COMPONENT

PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1	10-30-51
T.S.			
EL. 2			
RED			
BR			
ROCK.			
SCL.			

DRG PERTAINS TO

51-63 ASSMG-M20A1
B47889 OILER, BREECH,
ASSEMBLY.

TOLERANCE .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

C5564375

SCALE 1/

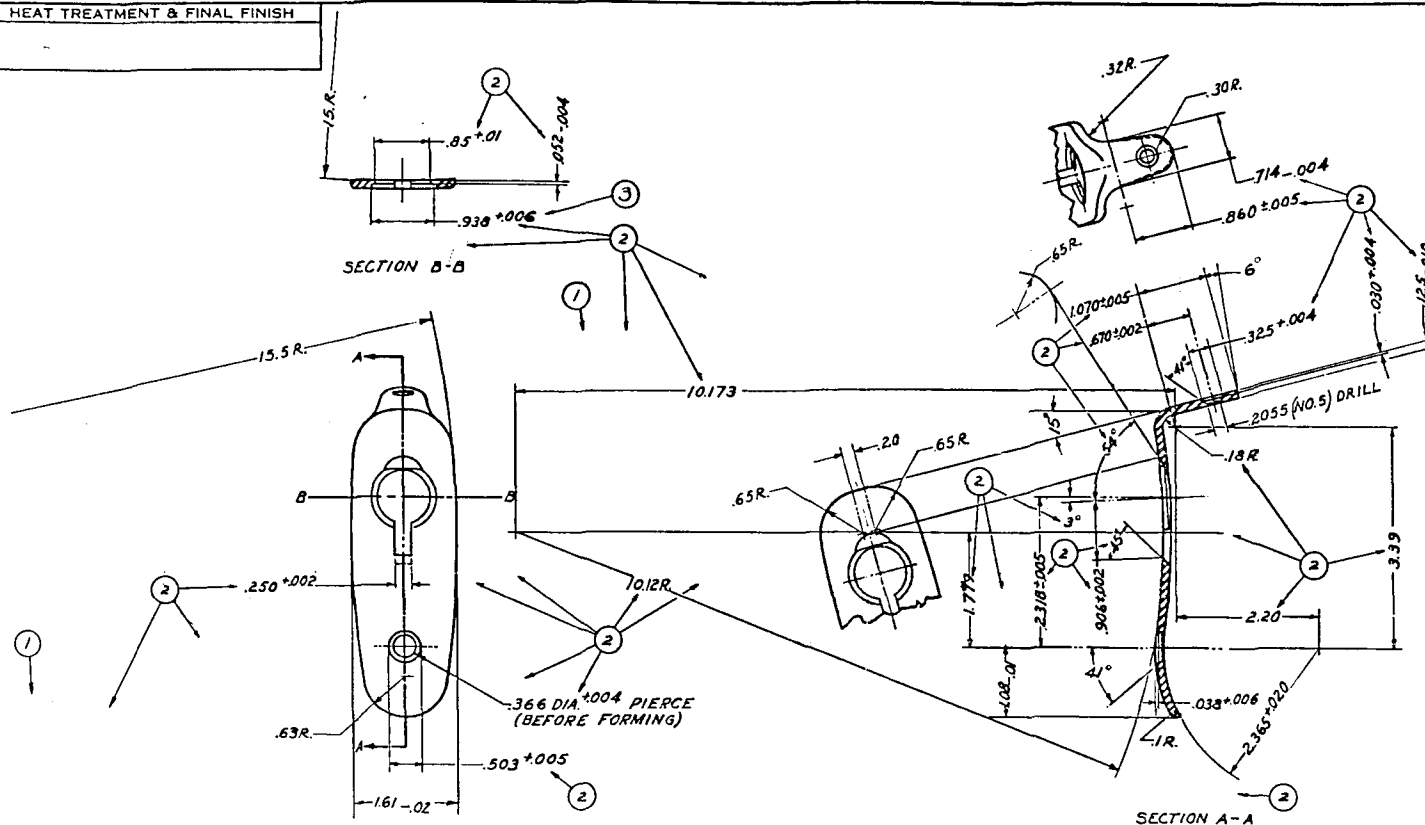
REF. DRG. A.O.C. 45-1-B

C64375

SYMBOL	
DESIGNED BY	LOG OFFICER
NAME	NAME
DATE	DATE
ENGINEER	ENGINEER
DATE	DATE
SUBMITTED	SUBMITTED
DATE	DATE
APPROVED BY	APPROVED BY
DATE	DATE
CHIEF OF ORDNANCE	CHIEF OF ORDNANCE
DATE	DATE
ORDNANCE DEPT USA	ORDNANCE DEPT USA

SUPERSEDES C64375

HEAT TREATMENT & FINAL FINISH



5564376
 PLATE, BUTT
 FINISH
 MANUFACTURING COMPONENT
 1 2 3

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1 st	4-27-41
T.S.		2 nd	12-30-41
EL.2		3 rd	4-10-44
RED.		4 th	5-30-47
BR.			
ROCK.			

DRG. PERTAINS TO	
51-63	155.MG-1129A1
664383	PLATE, BUTT, ASM.

DESIGNED	CHECKED	130 OFFICIAL
208	58	6/1K
CHECKED	BY	CHIEF ENGINEER
6/1K	W. J. 34	..
SUBMITTED		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		

REF. DRG. A.Q.C. 15-6-4

5564376

SCALE

664376

SUPERSEDES 664376

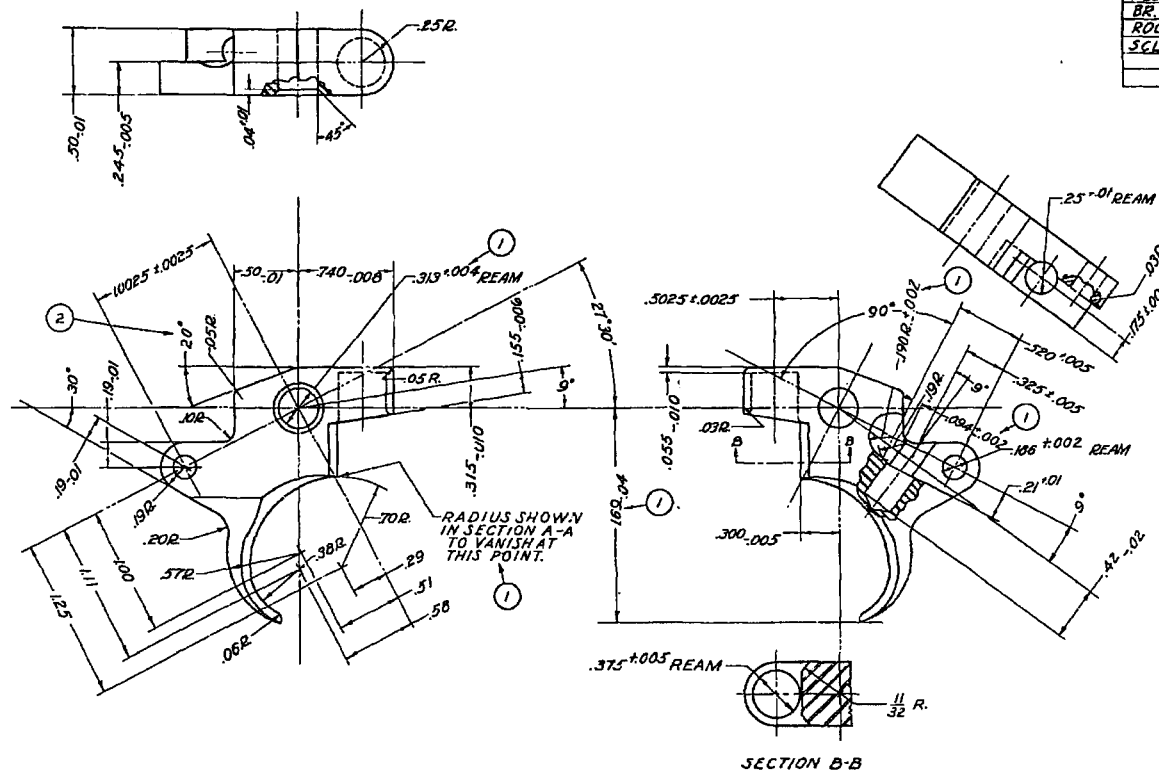
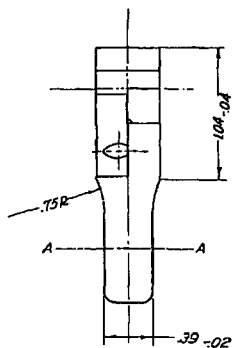
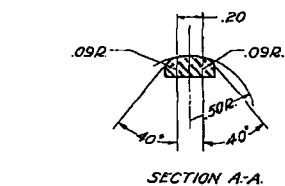
C5564376

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES	DEC. 31, 1941	
	REVISIONS	
Y.R.	1 st	9-30-42
T.S.	2 nd	12-8-44
EL. 2	3	10-30-51
RED		
BR.		
ROCK.		
SCL.		

DRG PERTAINS TO

51-63	45 S.M.G.-M20A
51-116	45 S.M.G.-M1
51-124	45 S.M.G.-M1



TRIGGER ~~C-64378-2~~ 5564378
FINISH f^d

TOLERANCE ~~NOT~~ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

REF.DA.G.AQC.A42-36

C5564378

SCALE $\frac{1}{4}$

~~C-64378~~

[illegible]

STYMAN	TRACER	120807-2
WED	WED	6.1.02
CHECKER	6.1.02	CHIEF OF TS
6.1.02		6.1.02
SUBMITTED		

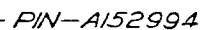
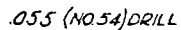
APPROVED BY ORDER OF THE
CHIEF OF RESERVANCE

COL. J. D. DEPT. U.S.
ORDNANCE DEPT. U.S.

SUPERSEDES C643

CEEC 4370

HEAT TREATMENT & FINAL FINISH



-CATCH-C64368

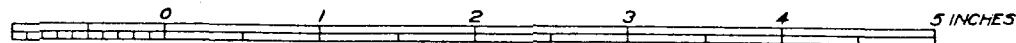


— 40 R. — 01

LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	C64380	CATCH, MAGAZINE, ASSEMBLY	1
2		COMPOSED OF :	
3	C64368	1- CATCH, MAGAZINE	*
4	A152994	1-PIN, MAGAZINE CATCH	*

CATCH, MAGAZINE, ASSEMBLY (C64380

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



REF. DRG. A.O.C. 45-1-7

C-64380

[illegible]

SYMBOL	
5564380	
PTS MAN	TRACER
H.U.O	W.D.G
CHARGER	W.D.G
SUBMITTED	
<p> <i>OKUD Sinter</i> LTCOL ORD DEPT U.S.A. APPROVED BY ORDER OF THE CHIEF ORDNANCE <i>John Ord</i> COL ORD DEPT U.S.A. ORDNANCE DEPT. U.S.A. </p>	

OBSOLETE

HEAT TREATMENT & FINAL FINISH

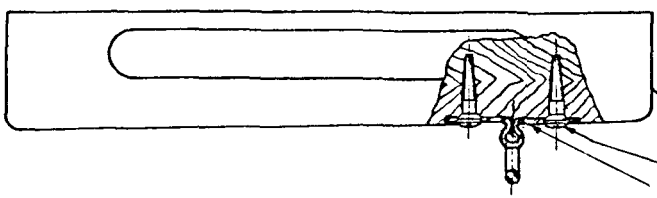
LEGEND

~~Q AUTHORIZED ASSEMBLY FOR S-F 45 SING. M1 & S-F 45 SING. M1A1~~
~~Q AUTHORIZED ASSEMBLY FOR S-F 45 SING. M1A1 (FOR ALTERNATIVE DESIGN SEE B147721)~~

PHYSICAL PROPERTIES		DEC. 31, 1941 REVISIONS	
Y.P.		2	3-3-43
T.S.		3	10-9-43
EL 2		4	4-20-45
RED		5	LOWERS TO 10-30-51
BR.			
ROCK.			

DRG. PERTAINS TO

51-116	45 SING. M1
51-63	45 SING. M1A1
51-124	45 SING. M1A1



SWIVEL-A153029
 GRIP-C64371
 SCREW-A153013
 PLATE-B147716

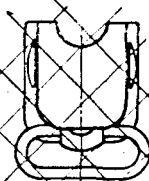
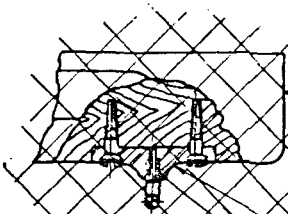
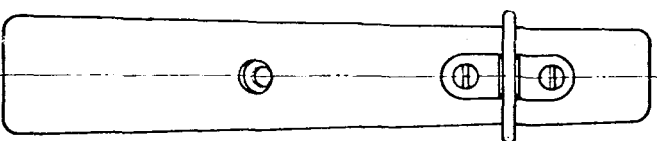
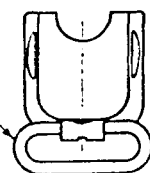


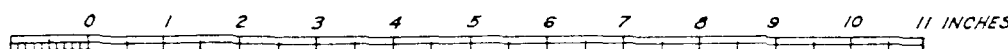
PLATE-B147681
 PIN-A152998

FRAGMENTARY VIEWS SHOWING COMPONENT PARTS OF SLING SWIVEL ASSEMBLY-B147682

LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	C64381	GRIP, FORE, HORIZONTAL, ASSEMBLY	1
2		COMPOSED OF-	
3	C64371	1-GRIP, FORE, HORIZONTAL	
4	A153013	2-SCREW, SLING SWIVEL PLATE	
5	B147721	1-SWIVEL, SLING, ASSEMBLY	
6	B147682	1-SWIVEL, SLING, ASSEMBLY	
7			

5564381
 GRIP, FORE, HORIZONTAL, ASSEMBLY C64381



SUPERSEDES OLD TRACING C64381 UNDER REVISION DATE OF MAR. 3, 1943

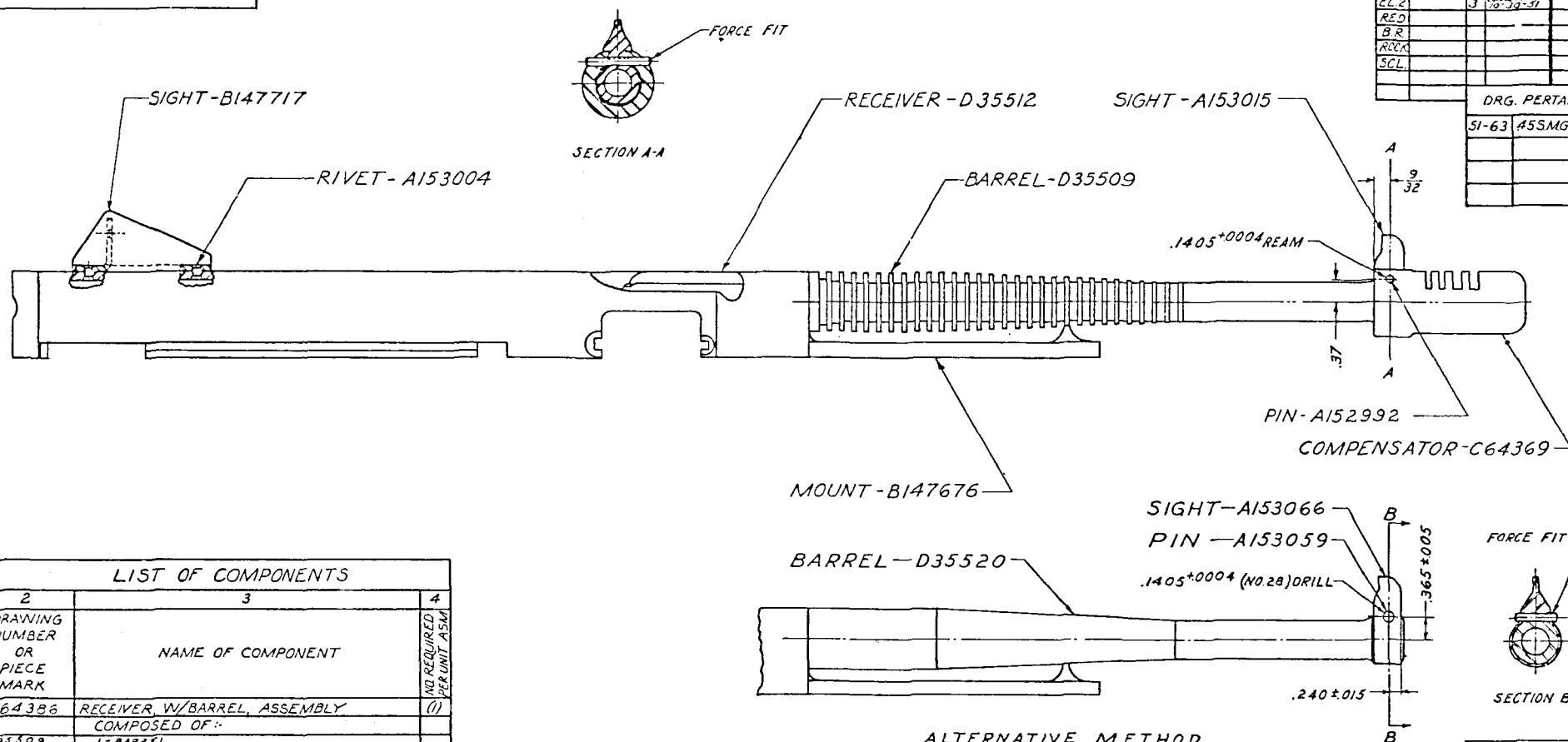
C5564381
 C64381

DESIGNED <i>[Signature]</i>	TRACED <i>[Signature]</i>	LDG. OFFICER <i>[Signature]</i>
CHECKED <i>[Signature]</i>	CHIEF OFFICER <i>[Signature]</i>	SA <i>[Signature]</i>
SUBMITTED <i>[Signature]</i>		
ORD. ENG. ORD. DEPT. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE. <i>[Signature]</i>		
ORD. DEPT. ORDNANCE DEPT., U. S. A.		

SUPERSEDES C64381

HEAT TREATMENT & FINAL FINISH.	

PHYSICAL PROPERTIES		DEC. 31, 1941 REVISIONS	
Y.P.	1	9-8-42	
T.S.	2	12-30-43	
EL 2	3	10-19-41	
RED			
B.R.			
REXX			
SCL			
		DRG. PERTAINS TO	
		SI-63	A55MG-M2BA



LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASSEMBLY
1	C64386	RECEIVER, W/BARREL, ASSEMBLY	(1)
2		COMPOSED OF:-	
3	035598	1-32325 (ALTERNATE)	
4	C64369	1-COMPENSATOR, RECOIL	
5	B14768	1- MOUNT, GRIP	
6	A133333	1- PIN FRONT SIGHT	
7	C64385	1-RECEIVER, ASSEMBLY	
8	A133015 A133066	1- SIGHT, FRONT	
9			
10			

⊙ USED ONLY WHEN BARREL-D35509 IS USED.
⊕ USED ONLY WHEN BARREL-D35520 IS USED.

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

ALTERNATIVE METHOD
RECEIVER, W/BARREL, ASSEMBLY ⁵⁵⁶⁴³⁸⁶ ~~(C-64306)~~

C5564386

~~664388~~

OFFICIAL TRACKER U.S. OFFICIAL
 a/b a/b b/t
 OFFICIAL U.S. OFFICIAL
 b/t a/b b/t
 SUBMITTED:
 John E. Smith
 LT COL DRD DEPT U.S.A.
 APPROVED BY CHIEF OF THE
 CHIEF OF ORDNANCE:
 John E. Smith
 CCA 240 DEPT U.S.A.
 ORDNANCE DEPT U.S.

SUPERSEDES C64386

HEAT TREATMENT & FINAL FINISH

STAKE LIGHTLY IN TWO PLACES WITH CENTER PUNCH.

NUT-A349854

SECTION A-A

WASHER-A349852

SCREW-A349853

FRAGMENTARY VIEW

CAP — B147758

PIN — A152990

SPRING-A153115

PLATE-C64376

SCREW-A153006

STOCK-D35513

SLIDE-C64377

BUTTON-A152984

PLATE-B147716
SWIVEL-A153029

ALTERNATIVE DESIGN
SEE DRAWING B147721

PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1	2-1-43
T.S.		2	10-9-43
EL. 2		3	12-30-43
RED		4	4-20-45
BR.		5	10-30-51
ROCK.			
SCL.			

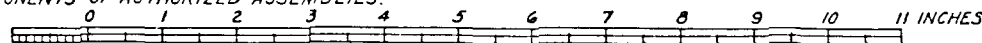
DRG PERTAINS TO

51-63, 453MG-M2BA1

LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	C64387	STOCK, ASSEMBLY	1
2		COMPOSED OF:-	
3	B147687	1-CATCH, BUTT STOCK, ASSEMBLY	
4	A152991	1-PIN, BUTT STOCK CATCH	
5	C64384	1-PLATE, BUTT, W/CAP, ASSEMBLY	
6	A153005	1-SCREW, BUTT PLATE, LARGE	
7	A153006	1-SCREW, BUTT PLATE, SMALL	
8	A153008	1-SCREW, BUTT STOCK, LARGE	
9	A153065	1-SCREW, BUTT STOCK, SMALL	
10	A153013	2-SCREW, SLING SWIVEL PLATE	
11	C64377	1-SLIDE, BUTT STOCK	
12	A153017	1-SPRING, BUTT STOCK CATCH	
13	D35513	1-STOCK, BUTT	
14	B147721	1-SWIVEL, SLING, ASSEMBLY	
15	A153030	2-WASHER, BUTT STOCK SCREW	
16	A349854	1-NUT, REINFORCE SCREW	
17	A349853	1-SCREW, REINFORCE	
18	A349852	1-WASHER, REINFORCE SCREW	

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



5564387

STOCK, ASSEMBLY C64387-3

C-5564387

REF. DRG. A.O.C. 45-6-1

C-64387

SYMBOL

WITNESSED BY: [Signature]
CHIEF OF ORDNANCE
SUBMITTED: [Signature]

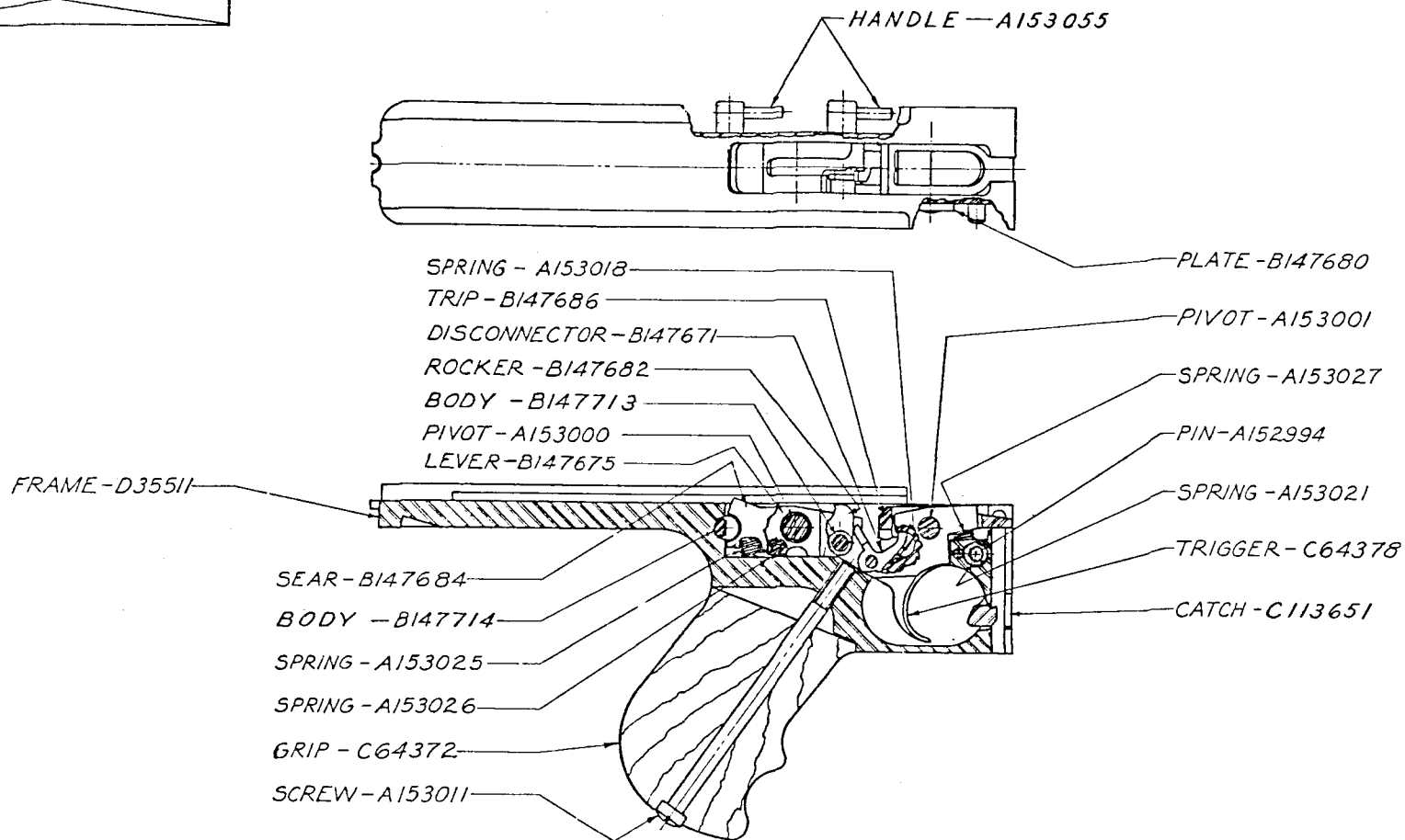
WITNESSED BY: [Signature]
CHIEF OF ORDNANCE
SUBMITTED: [Signature]

ORDNANCE DEPT USA

SUPERSEDES C64387

C5564387

HEAT TREATMENT & FINAL FINISH



MECHANISM, TRIGGER, FINDING DIAGRAM (5564388)



PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1	1/2-30-43
T.S.		2	10-30-43
EL2			
RED.			
BR.			
ROCK.			

DRG. PERTAINS TO

51-63 45SMG-M28A1

DESIGNER	TRACER	CON. DESIGNER
438	438	614
CHECKER	TRACER	CON. CHECKER
614	614	614
SUBMITTED:		

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:

LT COL. ORD DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:
ORDNANCE DEPT. U. S. A.

C5564388

C64308

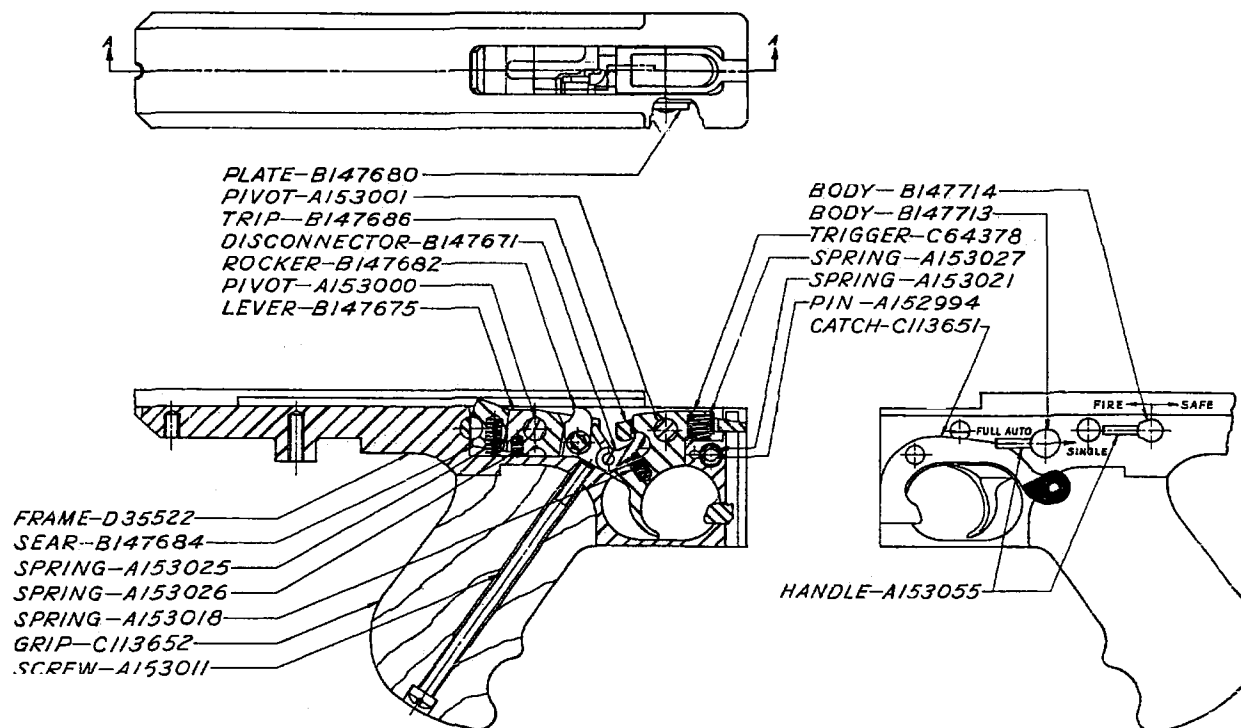
5564388

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES		APRIL 30, 1942	
		REVISIONS	
Y.P.		1	4-19-42
T.S.		2	10-31-42
EL.2			
RED.			
BR.			
ROCK.			

DRG. PERTAINS TO

51-116 45 SM.G.MI
51-124 45 SM.G.MI



SUPERSEDES OLD TRACING C113658 UNDER REVISION DATE OF APRIL 19, 1943

C5613658
C113658

OFFMAN	FORGER	LOG OFFICER
MFB	MFB	WCA
CHECKER		CHEF OFFICER
SA		SA
SUBMITTED		
BY ORDN. ENG. DEPT.		
APPROVED BY ORDER OF THE		
CHIEF OF ORDNANCE		
W. B. B. B.		
ORDNANCE DEPT. U. S. A.		

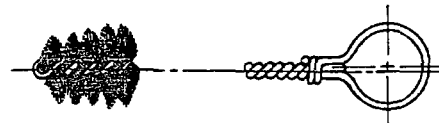
SUPERSEDES C113658

C5613658

NOTES:

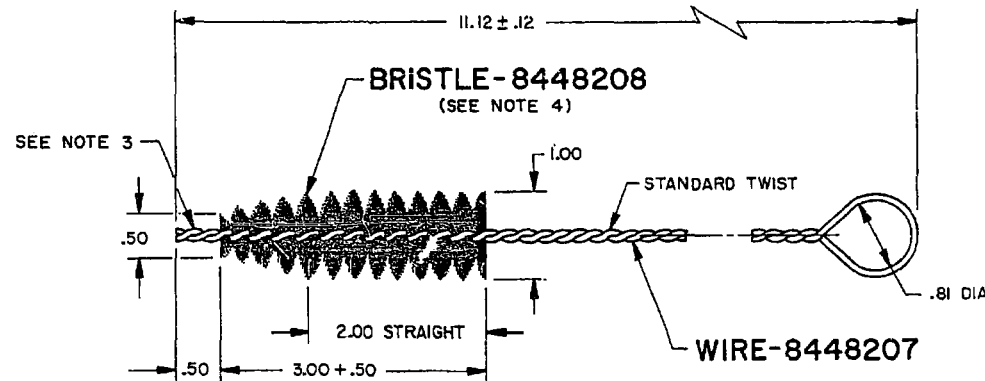
1. FOR ALTERNATIVE MANUFACTURE, NYLON BRISTLES .010 DIA + .003 MAY BE USED; EITHER BLACK OR WHITE.
2. WEIGHT OF BRISTLES: MIN 2.35 GRAMS. WEIGHT OF ASSEMBLED BRUSH: APPROX 16.4 GRAMS.

3. SOLDER, COMP SN50 OR SN40 OF SPEC QQ-S-571. DIAMETER NOT TO EXCEED .18 AFTER SOLDERING.
4. BRUSH SHALL HAVE 12 TO 13 COILS.
5. MIL-B-20100 SHALL APPLY.



ALTERNATIVE CONSTRUCTION

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
1		A	REDRAWN & REVISED W/CHG SEE EO 82076	16 APR 68
2		B	SEE EO 82192	18 JULY 68
3		C	SEE ERR HQR 30633	23 FEB 73
4		D	SEE ERR HQR 30658	9 APR 73
5		E	(1) SEE NOR 77E0001-0002	5 JAN 77
6		F	NOR WIS2007/810610	880602



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

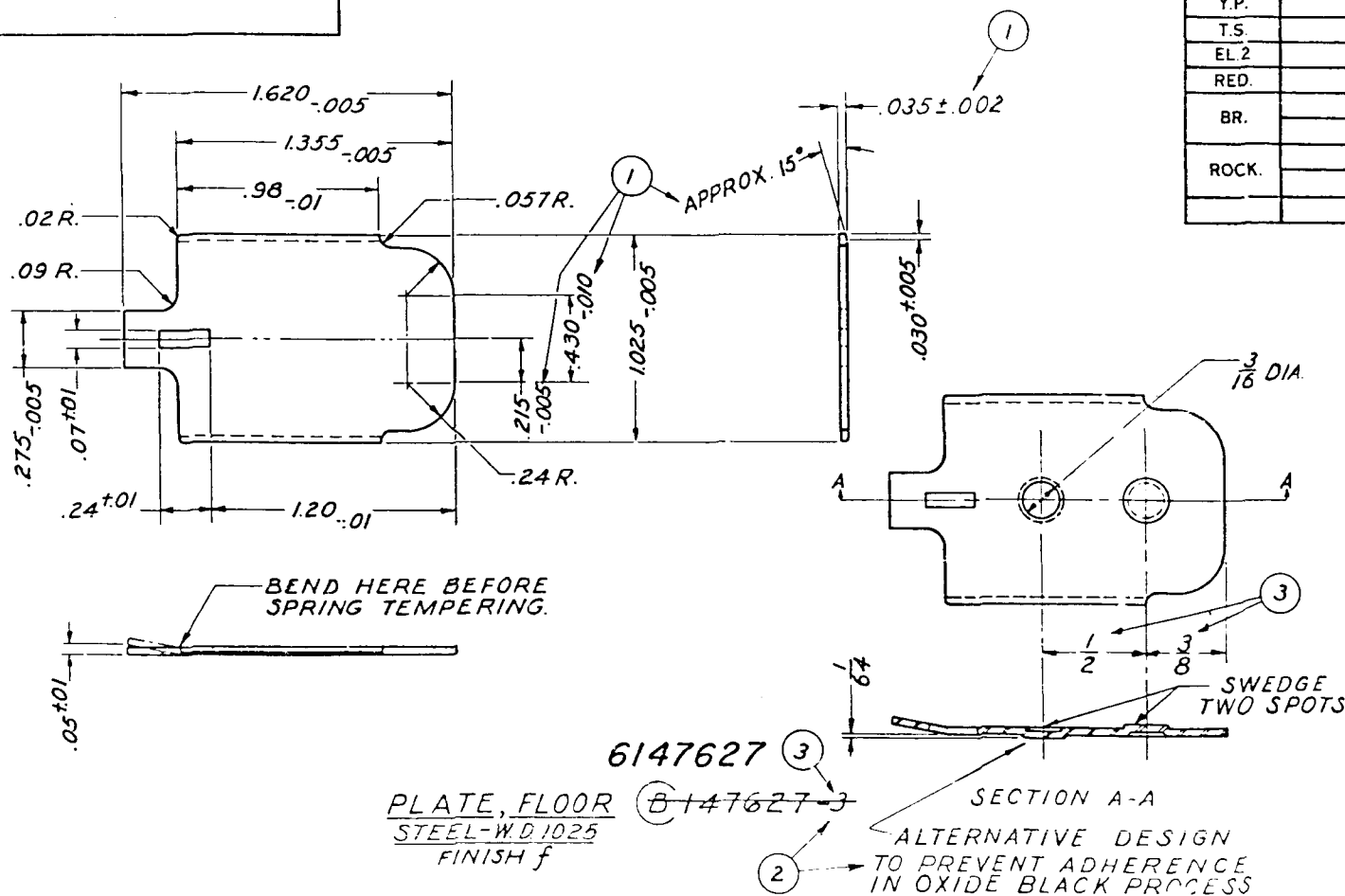
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST- 6108828

PART NO. 6108828

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 JUNE 1934		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP	A12006364	RIFLE,	TOLERANCES ON DECIMALS XX ± .06	DRAFTSMAN	RSB	CHECKER	APR
TS		SPOTTING,	ANGLES ± XXX ±	TRACER	H. A. Garfield	CHECKER	H. A. Garfield
EL 2		CAL..50, M8C	MATERIAL	ISSUED	W. H. Knevel	CHECKER	W. H. Knevel
RA	A12002939	SMG, M38 M3A1	HEAT TREATMENT	SUBMITTED	Philip E. Heberle		
BH	A12002930	RIFLE, CAL.30, M1918A2	FINAL PROTECTIVE FINISH	APPROVED	R. S. Henry		
RH		NEXT ASSY. USED WITH					
		APPLICATION					

DWG SIZE	CODE IDENT NO.	
C	19204	6108828
SCALE 1/1	UNIT WT	SHEET 1 OF 1

PENTRATĒ



TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147627

SCALE $\frac{2}{1}$

REF. DRG. S.A.15306

~~B147627~~

PHYSICAL PROPERTIES		AUGUST 28, 1941			
		REVISIONS			
Y.P.		1 ³	12-20-41		
T.S.		2 ¹	10-12-42		
EL.2		3 ²	11-18-42		
RED.		4	CONVERSION 10-30-51		
BR.					
ROCK.					

DRG. PERTAINS TO

D35500	MAGAZINE, BOX,
	20 CARTRIDGE
DJ5506	MAGAZINE, BOX,
	30 CARTRIDGE

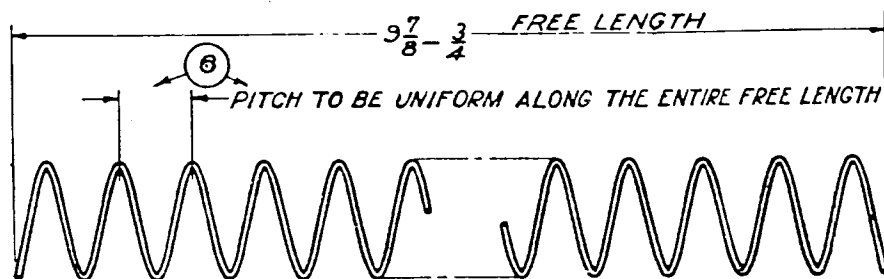
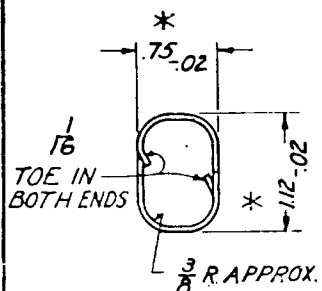
DFTSMAN	TRACE 1	L'DG. DFTSMAN
W. L. M.	H. M. F.	B. J. T.
CHECKER	SA J. A. 50 E. G. H.	CHIEF DFTSMAN E. J. M. SA

LT. COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

WT Moore
MAJOR ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

86147627

HEAT TREATMENT & FINAL FINISH



- MAXIMUM SOLID HEIGHT----- $1 \frac{1}{8}$
- MEAN ASSEMBLED HEIGHT----- $5 \frac{27}{32}$
- *LOAD AT MEAN ASSEMBLED HEIGHT-----4 LBS. $\pm \frac{1}{2}$ LB.
- *DIAMETER OF WIRE-----.054
- TOTAL NUMBER OF COILS-----14 ± 1
- *LOAD AT MINIMUM OPERATING HEIGHT-----10 LBS. ± 1 LB.
- TYPE OF ENDS-----SPECIAL AS SHOWN
- WOUND-----RH OR LH
- MINIMUM OPERATING HEIGHT----- $1 \frac{5}{32}$

SPRING, MAGAZINE B147628 6147628
 * SPRING STEEL WIRE - WD 1085 SPECIAL
 OR WD 1095 SPECIAL

* MANDATORY

TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
 SUPERSEDES OLD TRACING B147628 UNDER REVISION DATE OF APRIL 20, 1942

SCALE $\frac{1}{1}$

B6147628

B147628

PHYSICAL PROPERTIES		AUGUST 28, 1941			
		REVISIONS			
Y.P.		4	4-20-42		
T.S.		5	5-6-42		
EL.2		6	11-23-43		
RED.		7	11-20-46		
BR.		8	CONVERSION 10-30-51		
ROCK.					

DRG. PERTAINS TO

D35500 MAGAZINE, BOX,
 20 CARTRIDGE

DFTSMAN	TRACER	L'DG. DFTSMAN
W. H. S.	H. M. F.	G. J. F.
CHECKER	3. A.	UNIFORMER
B. H.	E. G. W.	3. A.

SUBMITTED

W. H. S. 11/22/42

LT. COL. ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

W. H. S.

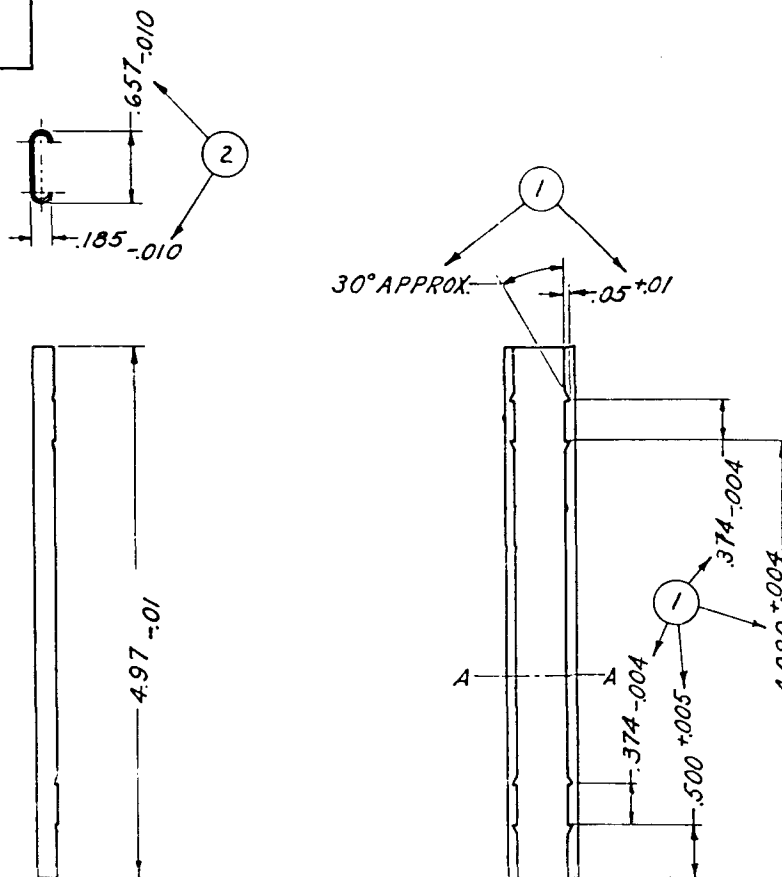
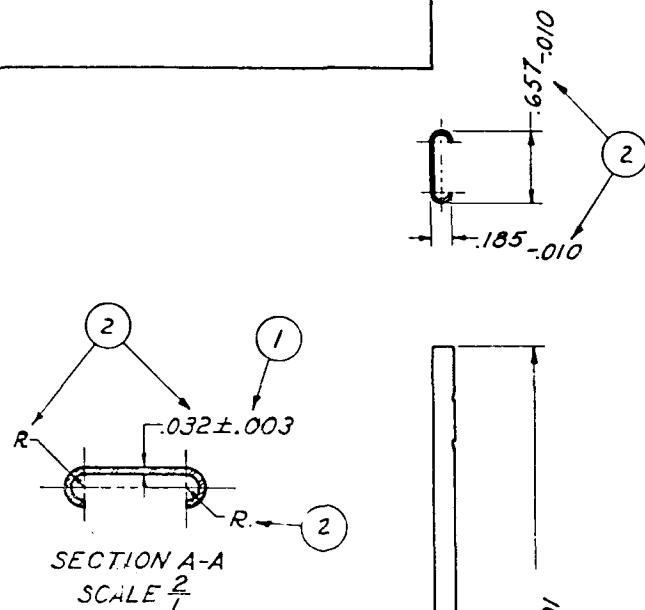
MAJ. ORD. DEPT. U. S. A.

ORDNANCE DEPT. U. S. A.

SUPERSEDES B147628

B6147628

HEAT TREATMENT & FINAL FINISH



STRIP, MAGAZINE BODY GUIDE (B-147629-2 6147629)
 STEEL-W.D.1025
 FINISH F
 MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147629

SCALE 1/1

REF. DRG. S.A. 15305

B-147629

PHYSICAL PROPERTIES		AUGUST 20, 1941			
		REVISIONS			
Y.P.		1 st	1-2-42		
T.S.		2 nd	11-16-42		
EL 2		3	10-30-57		
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

C64349 TUBE, MAGAZINE, ASH
 D35500 MAGAZINE, BOX,
 20 CARTRIDGE

DFTSMAN	TRACER	LDC. DFTSMAN
H.J.O.	H.M.F.	G.J.O.
CHECKER	CHIEF DFTSMAN	
G.M.	E.G.W.	SA 00

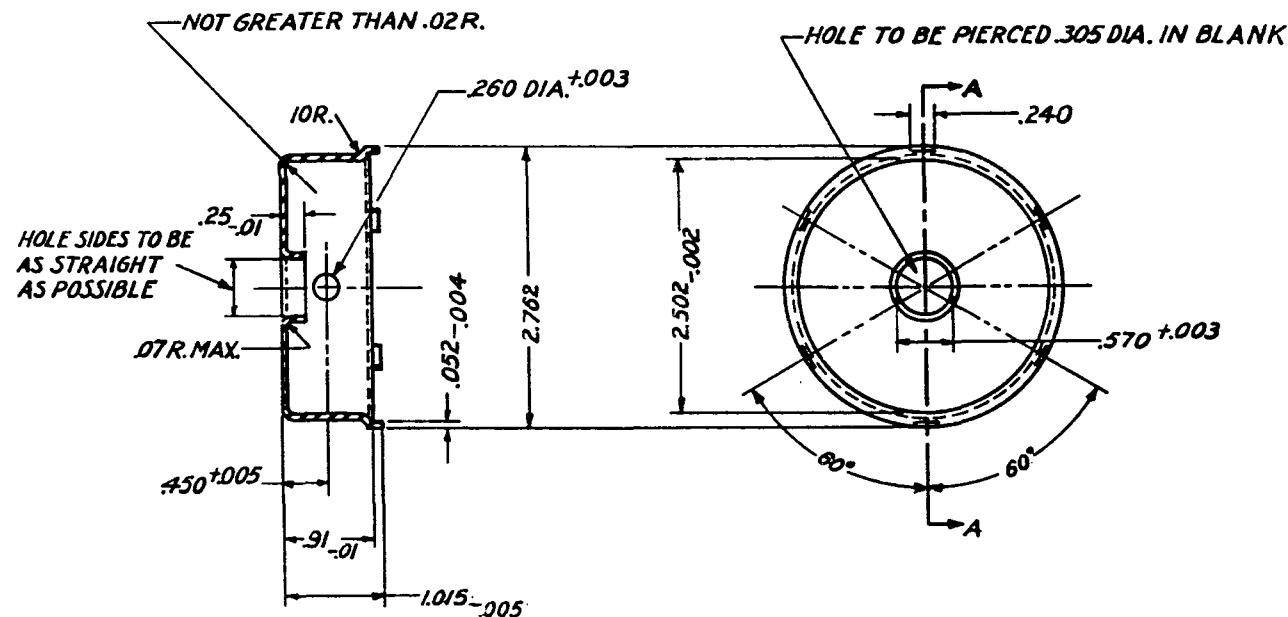
SUBMITTED
 LT COL. O.P. DEPT. U.S.A.
 APPROVED BY ORDER OF THE
 CHIEF OF ORDNANCE.
 MAJ. ORD. DEPT. U.S.A.
 ORDNANCE DEPT., U.S.A.

B6147629

SUPERSEDES B147629

HEAT TREATMENT & FINAL FINISH

PENTRATE



SECTION A-A

CASE, ROTOR SPRING (B-147650-6147650)
STEEL-W.D 1010
FINISH "F"
MANUFACTURING COMPONENT

TOLERANCE± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147650

SCALE 1/1

REF: UNITED AIR CLEANER CO. DRG. NO. 50,015

PHYSICAL PROPERTIES		OCTOBER 20, 1941	
		REVISIONS	
Y.P.		1	CONVERSION 10-30-57
T.S.			
EL 2			
RED.			
BR.			
ROCK.	B-31-36		

DRG. PERTAINS TO

D35505 MAGAZINE, DRUM.
50 CARTRIDGE
D35504 ROTOR, ASSEMBLY

OFFICER	TRACER	L.D. OFFICER
a.j.f.	a.j.f.	b.f.f.
CHECKER	EGW	SAI
SUBMITTED		
LT. COL. ORG. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
J. J. J. J.		
COL. ORG. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

SUPERSEDES B147650

B6147650

PHYSICAL PROPERTIES		OCTOBER 20, 1941			
		REVISIONS			
Y.P.		/	CONVERSION 10-30-51		
T.S.					
EL.2					
RED.					
BR.					
ROCK.	B-46-47				

Technical drawing of a rectangular plate. The top-left corner is rounded with a radius of $.05 R$. The top-right corner is chamfered with a $.02 R$ chamfer. The bottom-left corner is chamfered with a $.02 R$ chamfer. The bottom-right corner is rounded with a radius of $.02 R$. The plate has two circular holes, one on each side, with a center-to-center distance indicated by a dashed line.

D35505	MAGAZINE, DRUM, 50 CARTRIDGE
C64358	BODY, MAGAZINE, ASSEMBLY

OFFTSMAN	TRACER	LDS. OFFTSMAN
V.W. L.	H.M.F.	C.P.G.
CHECKER	SA M.B. EGW	CHIEF OFFTSMAN
SA L.M.		SA M.B. C.C.
SUBMITTER		

SUBMITTED: *9*
Miller Sutton
LT. COL. ORDN. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE: *J. H. ...*
COL. ORDN. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

DEFLECTOR, CARTRIDGE (B) 147651 6147651
STEEL - WD 1010
 FINISH "F"
 MANUFACTURING COMPONENT

REF: UNITED AIR CLEAN-
ER CO. DRG. NO. 50,014

TOLERANCES .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

86147651

SCALE $\frac{2}{1}$

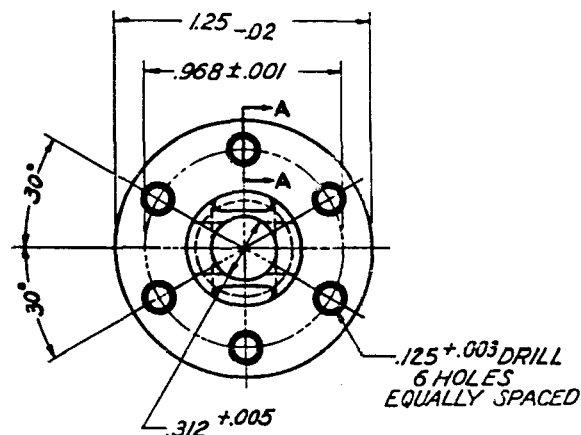
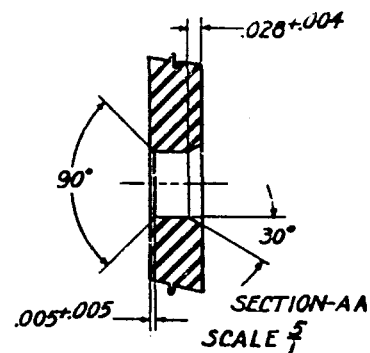
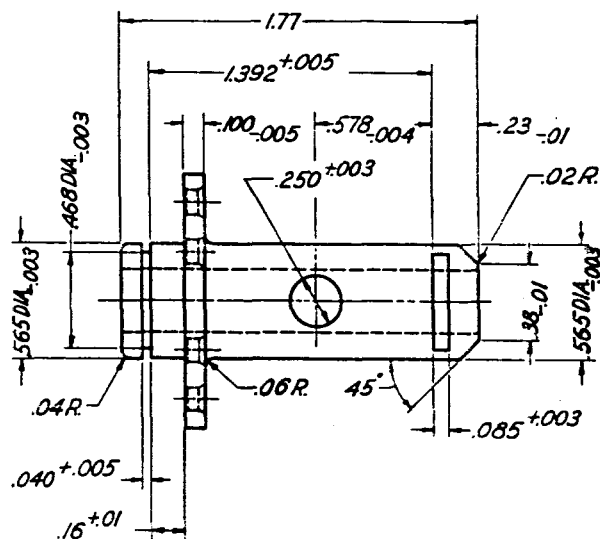
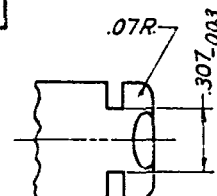
~~B-47651~~

SUPERSEDES 8147651

86147651

HEAT TREATMENT & FINAL FINISH

BLUE IN NITER



HUB (B) 47652-6147652
 STEEL ES BLUED SPEC. 30-5-333
 FINISH "f"
 MANUFACTURING COMPONENT

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147652

SCALE 2/1

REF: UNITED AIR CLEANER CO. DRG. NO. 30.019.

B147652

PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

OCTOBER 20, 1941

REVISIONS

1 st	6-13-50		
2	CONVERSION 10-30-51		

DRG. PERTAINS TO

D35505 MAGAZINE, DRUM,
 50 CARTRIDGE.
 C64363 RATCHET, ASSEMBLY.

DFTSMAN	TRACER	L'DE DFTSMAN
J.M.S.	J.M.S.	6/19
CHECKER	CHIEF DFTSMAN	
6/19	6/19	6/19

SUBMITTED

Walter J. Anton

LT. COL., ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

Walter J. Anton

COL., ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

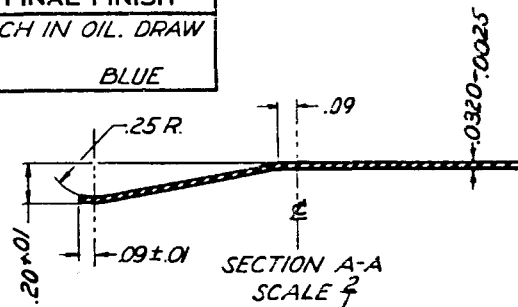
SUPERSEDES 3147652

B6147652

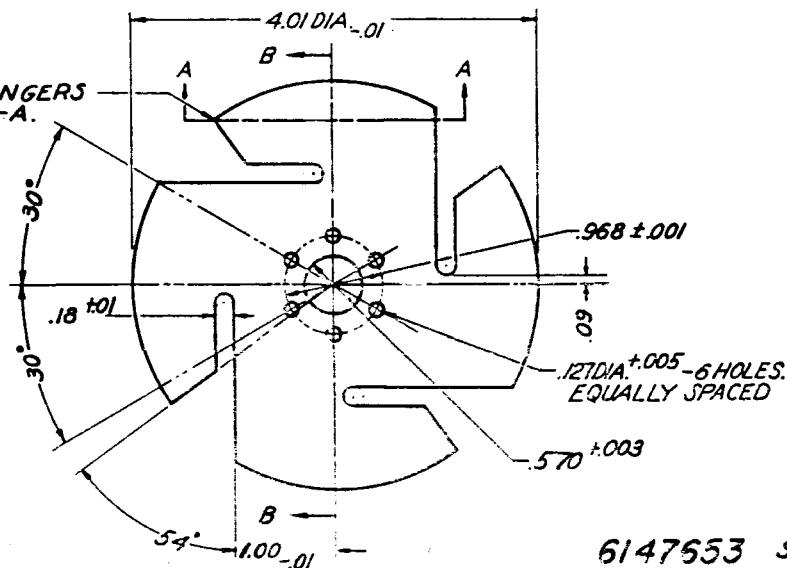
HEAT TREATMENT & FINAL FINISH

HEAT TO 1420°F. QUENCH IN OIL. DRAW AT 920°F.

BLUE



BEND ALL FOUR FINGERS AS IN SECTION A-A.



6147553 SECTION B-B

RATCHET 6147553 SCALE 1/2

STEEL WD 1075 SPECIAL

FINISH 1/2"

MANUFACTURING COMPONENT

TOLERANCE ±.01 ALLOWED IN ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

6147553

SCALE 1/2

REF. UNITED AIR CLEANER CO. DRG. NO. 50,020

6147553

PHYSICAL PROPERTIES

Y.P.

T.S.

EL.2

RED.

BR.

ROCK.

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OCTOBER 20, 1941

REVISIONS

CONVERSION 10-30-51

DRG. PERTAINS TO

035505 MAGAZINE, DRUM,

50 CARTRIDGE.

C64363 RATCHET, ASSEMBLY.

DFTSMAN TRACER L'DG. DFTSMAN

U. N. S. U. N. S. G. J. F.

CHECKER CHIEF DFTSMAN

C. M. J. E. G. W. J. A. M. R.

SUBMITTED

Walter J. Sinton

1. T. COL., ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE

CHIEF OF ORDNANCE.

George J. Sinton

1. COL., ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES 3147553

B6147653

										DECEMBER 20, 1941	
										REVISIONS	
LINE	DRAWING	PIECE-MARK	FINDING DIAGRAM	MAGAZINE, BOX, 30 CARTRIDGE	MATERIAL	MATERIAL SPECIFICATION	QUANTITY REQUIRED FOR ONE ASSEMBLY	UNIT WEIGHT IN LBS. (SEE ITEM 9)	ASSEMBLY PARTS PER ASSEMBLY	REMARKS	CONVERSION 10-30-51
				LIST OF PARTS							
1	D6535506			MAGAZINE, BOX, 30 CARTRIDGE				.516			
2	D6535507		C5564366	BODY, MAGAZINE			1	.37	0 ☆		
3	B6147626		D6535506	FOLLOWER, MAGAZINE			1	.04	0		
4	B6147627		D6535506	PLATE, FLOOR			1	.01	0		
5	B6147667		D6535506	SPRING, MAGAZINE			1	.03	0		
6	B6147668		C5564366	STRIP, MAGAZINE BODY GUIDE			1	.06	0 ☆		
7											
8											
9											
10											
11											
12											
13											
14											
15											
16											
17											
18											
19											
20											
21											
22											
23											
24											
25											

DRG. PERTAINS TO
D35506 MAGAZINE, BOX,
30 CARTRIDGE

C.H.M. R.S. *C.H.M.*

Exam. *John W. ...*

25 kg

LT. COL. *W. M. ...*

BY ORDER OF THE
CHIEF OF ORDNANCE

CAPT. *W. M. ...*

ORD. OFFICE, WAR DEPT.

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES

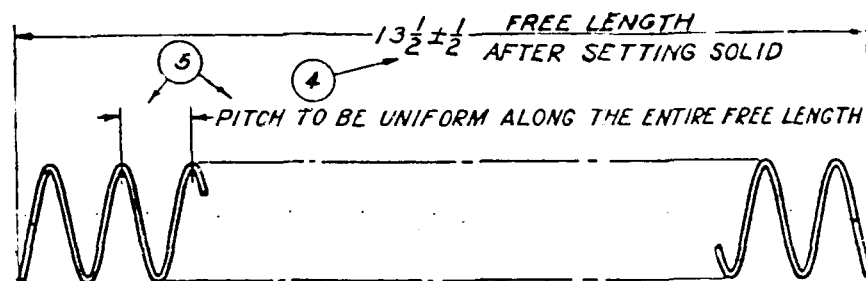
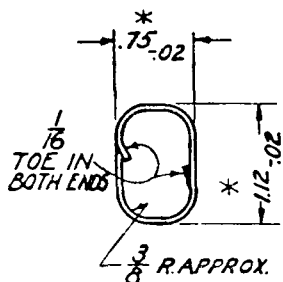
B6147665

147665

SHEET 1 OF 1 SHEET
SUPERSEDES B147665

B6147665

HEAT TREATMENT & FINAL FINISH	



- | | | |
|------------------------------------|-------|----------------------|
| * DIAMETER OF WIRE | ----- | .054 |
| TOTAL NUMBER OF COILS | ----- | 20 |
| TYPE OF ENDS | ----- | SPECIAL AS SHOWN |
| WOUND | ----- | R.H OR L.H |
| MEAN ASSEMBLED HEIGHT | ----- | 8.295 |
| LOAD AT MEAN ASSEMBLED HEIGHT | ----- | 4 LBS. $\pm 10\%$ |
| MINIMUM OPERATING HEIGHT | ----- | 1.176 |
| * LOAD AT MINIMUM OPERATING HEIGHT | ----- | 10.5 LBS. $\pm 10\%$ |
| MAXIMUM SOLID HEIGHT | ----- | 1.17 |

* SPRING, MAGAZINE ~~(B) 47667~~ 6147667
SPRING STEEL WIRE-WD 1085 SPECIAL OR
WD 1095 SPECIAL → (4) (5)

* MANDATORY

TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING B147667 UNDER REVISION DATE OF APRIL 20, 1942

SCALE $\frac{1}{4}$

PHYSICAL PROPERTIES		DEC. 20, 1941			
		REVISIONS			
Y.P.		3	4-20-42		
T.S.		4	2-22-43		
EL 2		5	11-23-43		
RED.		6	11-20-46		
BR.		7	CONFIRMATION 10-30-51		
ROCK.					

DRG. PERTAINS TO

D35506 MAGAZINE, BOX

30 CARTRIDGE

DFTSMAN	TRACER	L.D. DFTSMAN
H.M.F.	H.M.F.	C. J. O.
CHECKER	ISA	CHIEF DFTSMAN
C. J. O.	E. G. W.	ISA
SUBMITTED		
M. J. O.		

LT. COL. C. J. O. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

C. J. O.

CAPT. ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

4

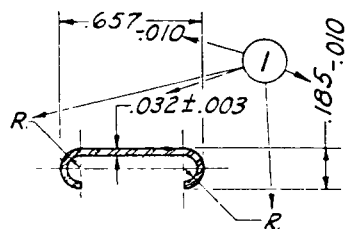
147667

47667

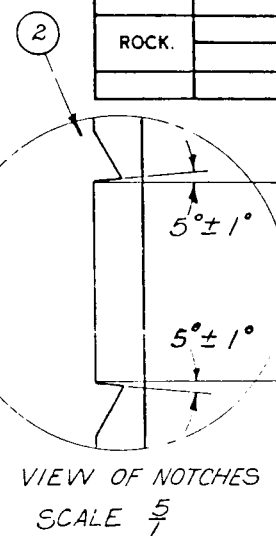
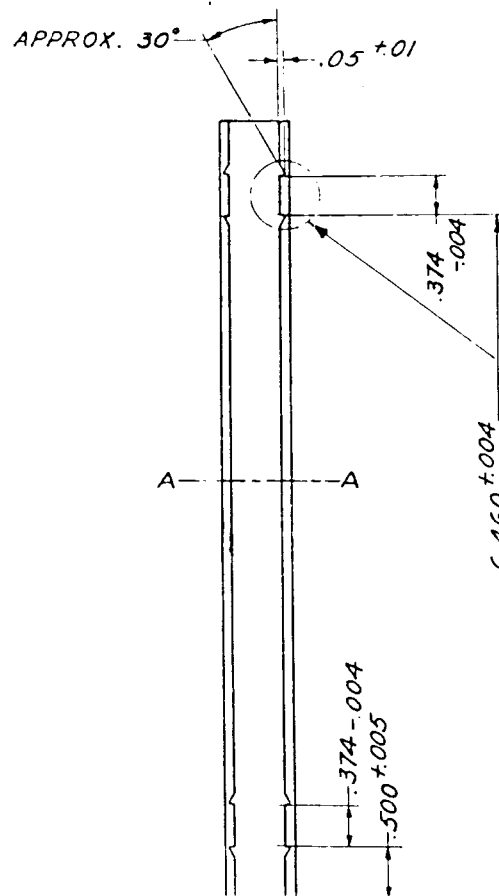
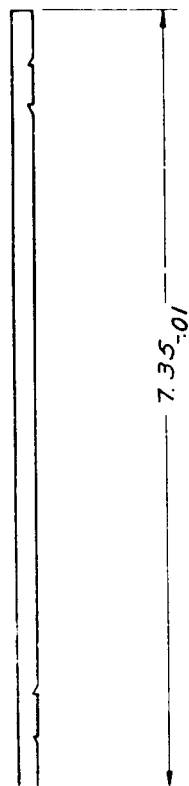
86147667

SUPERSEDES BLA7007

HEAT TREATMENT & FINAL FINISH



SECTION A-A
SCALE $\frac{2}{1}$



STRIP, MAGAZINE BODY GUIDE (B147668-2) 6147668
STEEL-W.D.1025
FINISH f
MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147668

SCALE $\frac{1}{1}$

REF. DRG. S.A. 15305

B147668

PHYSICAL PROPERTIES

Y.P.
T.S.
EL 2
RED.
BR.
ROCK.

DEC. 20, 1941
REVISIONS

1 ²	11-16-42		
2 ²	2-15-44		
3	CONVERSION 10-30-51		

DRG. PERTAINS TO

D35506 MAGAZINE, BOX,
30 CARTRIDGE.
C64366 TUBE, MAGAZINE, ASM

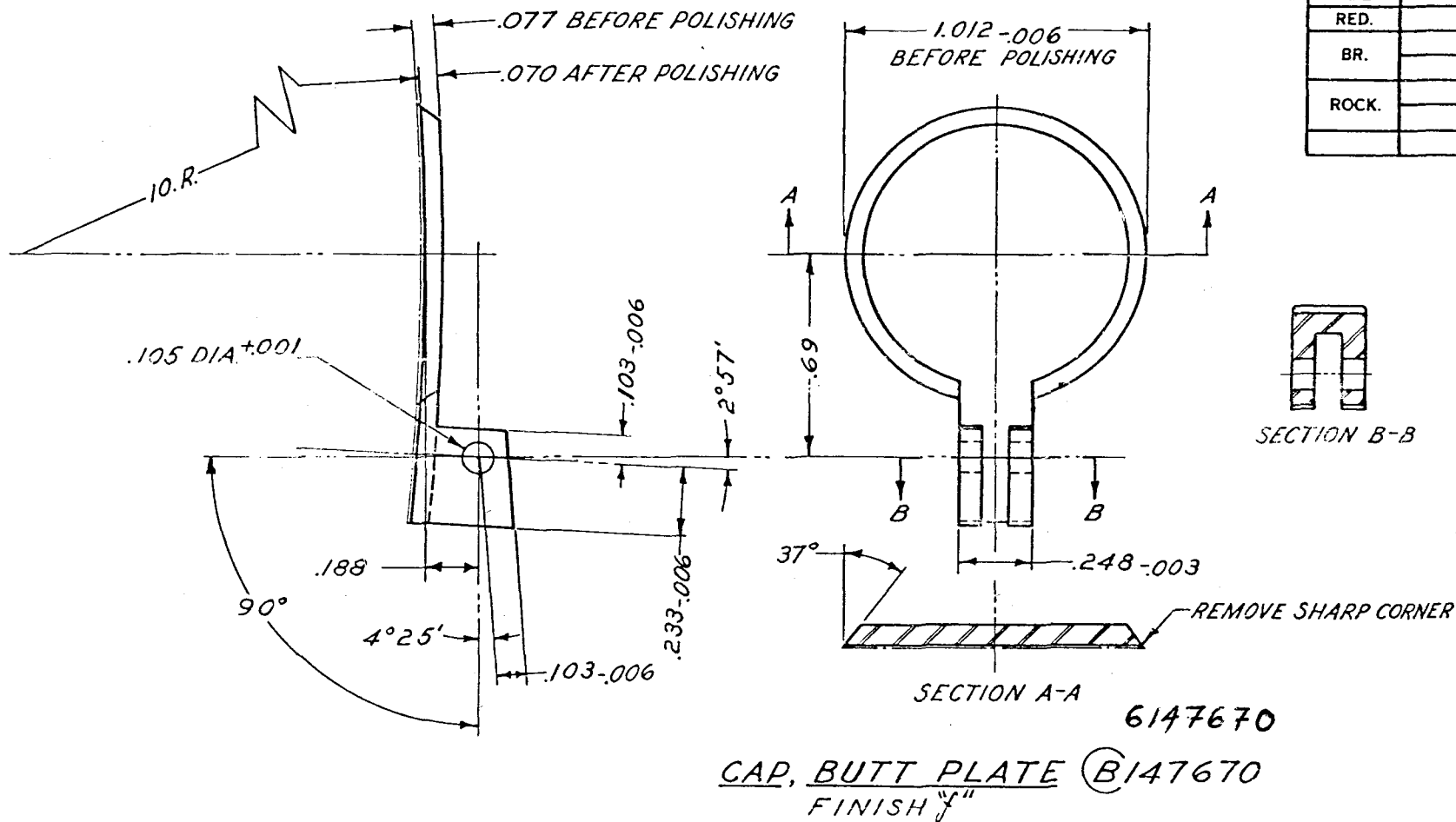
DFTSMAN H.M.F.	TRACER H.M.F.	LDC DFTSMAN R.J.F.
CHECKER C.M.	SA E.G.W.	CHIEF DFTSMAN SA O.O.

SUBMITTED
LT. COL. ORD DEPT. U.S.A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE
CAPT. ORD DEPT. U.S.A.
ORDNANCE DEPT., U.S.A.

SIIPRSFDFE R147668

B6147668

HEAT TREATMENT & FINAL FINISH



PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

DEC. 31, 1941.

REVISIONS

1	12-30-43		

DRG. PERTAINS TO

51-63 45SMG-M28A1
C64384 PLATE, BUTT,
W/CAP, ASM.

DFTSMAN D.F.P.	TRACER D.F.P.	L'DG DFTSMAN C.F.P.
CHECKER C.M.	CHIEF DFTSMAN E.G.W.	
SUBMITTED:		

APPROVED BY ORDER OF THE
CHIEF OF ORNANCE.

LT. COL. ORD. DEPT. U. S. A.
COL. ORD. DEPT. U. S. A.
ORNANCE DEPT. U. S. A.

B147670

HEAT TREATMENT & FINAL FINISH	

PHYSICAL PROPERTIES		DEC. 31, 1941			
		REVISIONS			
Y.P.		1'	9-30-42		
T.S.		2*	3-3-43		
EL.2		3 ²	12-30-43		
RED.		4	CONVERSION 10-30-51		
BR.					
ROCK.					

DRG. PERTAINS TO

51-63	455MG-M28A1
51-116	45 SMG-M1
51-124	45 S.M.G.-M1A1

OFFSMAN R.B.	TRACER W.L.M.	LOG OFFSMAN G.J.H.
CHECKER E.M.	SA EGW	CHIEF OFFSMAN SA 00

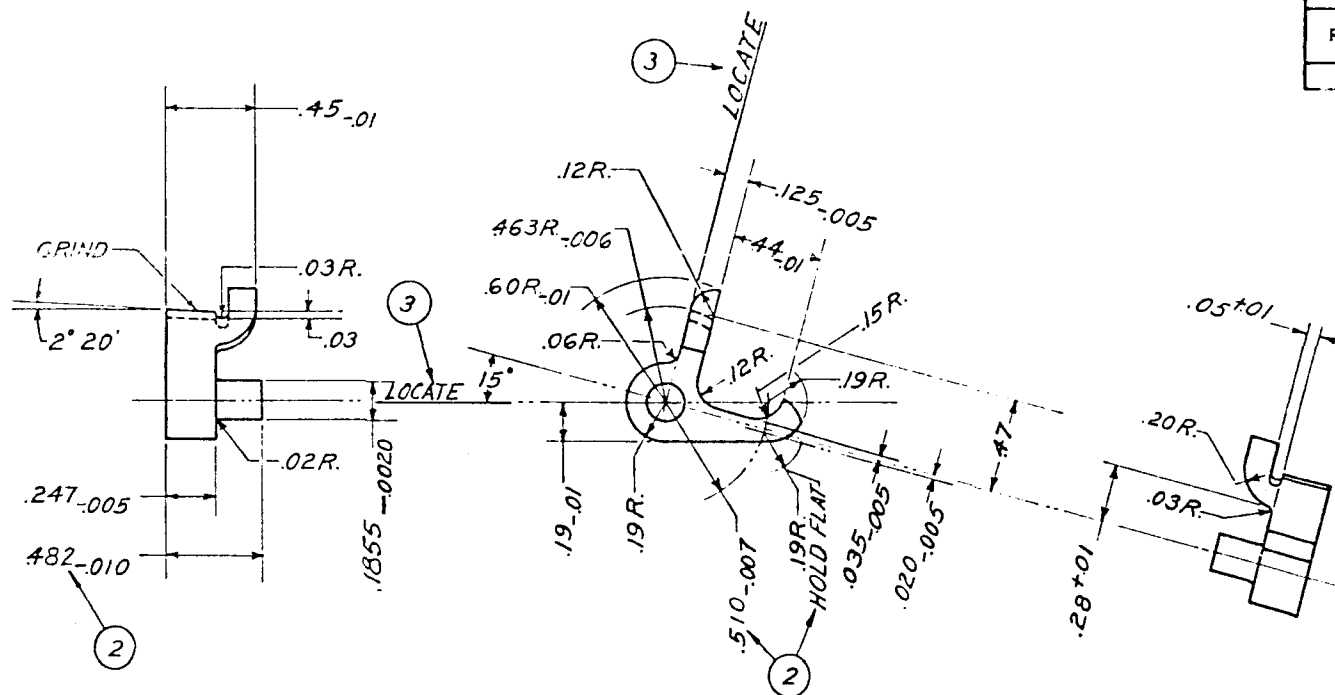
SUBMITTED:

W. L. G. S. S. S.
LT. COL. ORD. DEPT. U. S.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

John A. Smith
COL ORD. DEPT. U. S.

ORDNANCE DEPT., U. S. A.



DISCONNECTOR (B) ~~147671-2~~ 6147671
FINISH "f"

TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147671

SCALE $\frac{2}{1}$

REF. DRG. A.O.C.N 42-7

~~B147671~~

SUPERSEDES B147671

B6147671

LOCATING POINT

ENLARGED VIEWS SHOWING LOCATING POINTS.

SCALE $\frac{2}{1}$

PHYSICAL PROPERTIES		DEC. 31, 1941			
		REVISIONS			
Y.P.		1	12-30-43		
T.S.					
EL.2					
RED.					
BR.					
ROCK.					

51-63	45SMG-M28A1
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51-63	45SMG-M28A1
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[illegible][illegible][illegible]

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D'FTSMAN	TRACER	L'DG. D'FTSMAN
135	132	131

665	665	6.7.91.
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CHECKER A. J.	FILED	CHIEF OF TEAM A. J.
------------------	------------------	------------------------

L.M. ~~EGW~~ 20

SUBMITTED:-

1

Wells Ontar

APPROVED BY ORDER OF THE

CHIEF OF ORDNANCE:-

Johannes

COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

F DFC 30 1943

2025-03-20

NOTE: THREAD IN RECEIVER AND ON EJECTOR TO BE SO LOCATED AND MATCHED THAT WHEN SCREWED INTO POSITION THE EJECTOR WILL PROTRUDE AS SHOWN.

6147672

EJECTOR (B) 147672
FINISH"

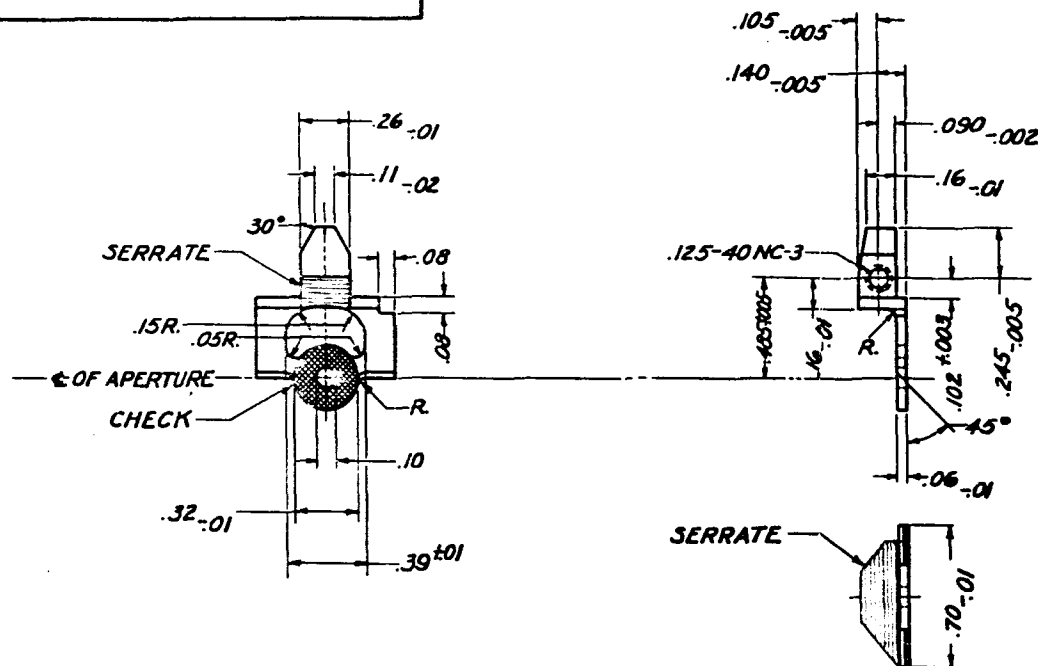
REF. DRG. A.O.C. 45-1-4

SCALE $\frac{2}{7}$

B/47672

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDED BY NEW TRACING C7310064 UNDER REVISION DATE OF DEC.30,1943

[illegible]

6147673
EYEPIECE (3) ~~6147673~~
FINISH f

TOLERANCE $\pm .01$ ALLOWED IN ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

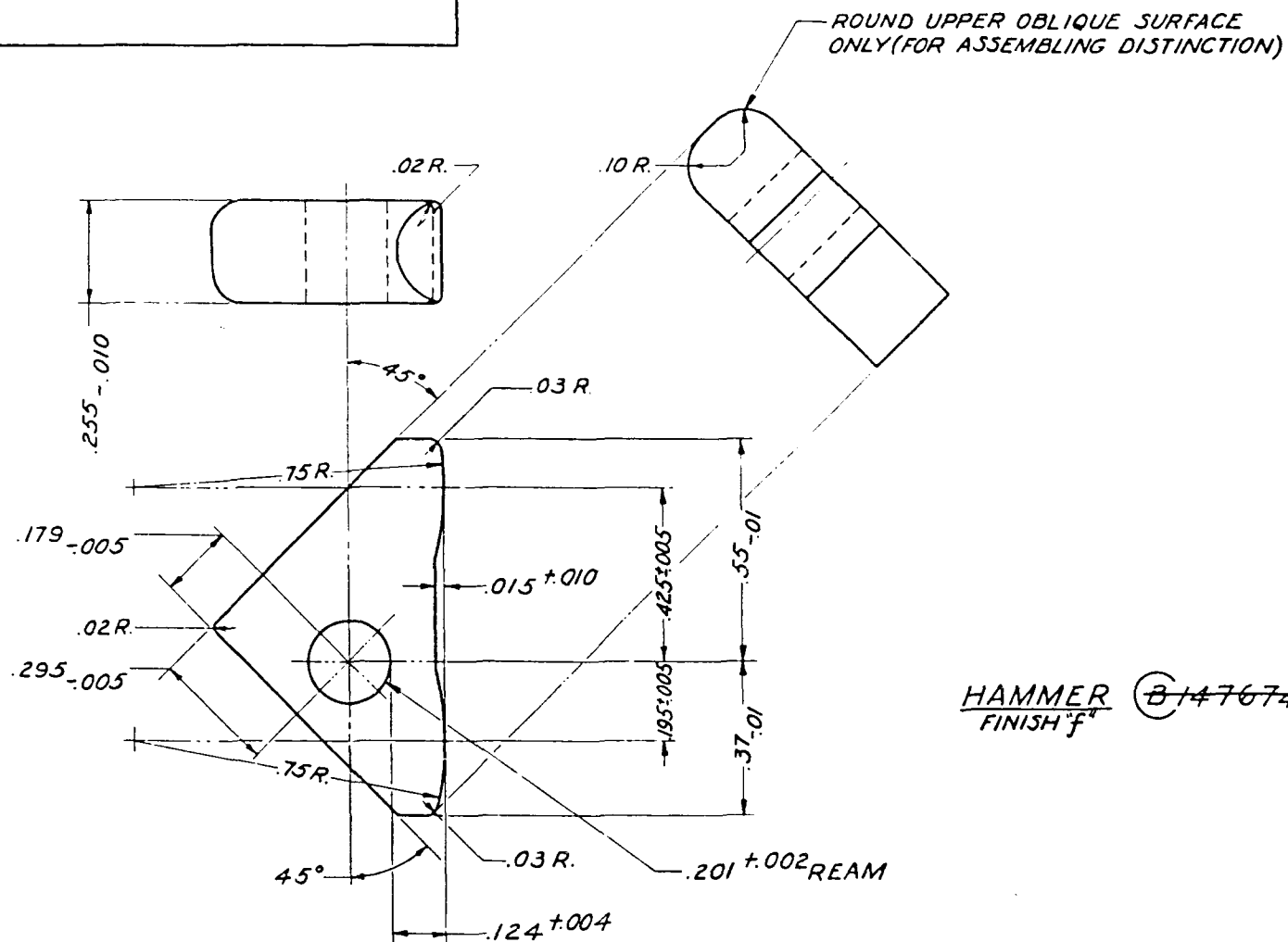
SCALE 3
B 6147673

REF. DRG. A.O.C. 45-7-2

SUPERSEDES B147673

86147673

HEAT TREATMENT & FINAL FINISH



TOLERANCE ± .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B 6147674 SCALE $\frac{4}{1}$

REF. DRG. A.O.C. 45-1-16

B 147674

PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED
BR.
ROCK.

DEC. 31, 1941

REVISIONS

Y.P.	T.S.	EL.2	RED	BR.	ROCK.
1	CONVERSION 10-30-51				

DRG. PERTAINS TO

51-63 45 SMG-M28 A1

DFTSMAN	TRACER	LOG DFTSMAN
H.M.F.	H.M.F.	G.J.O.
CHECKER	S.A.	CHIEF DFTSMAN
G.M.	EGW	J.A.

SUBMITTED..

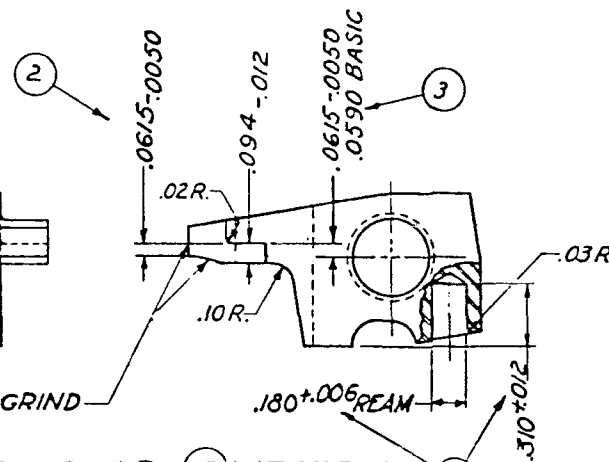
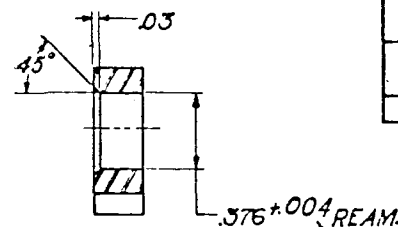
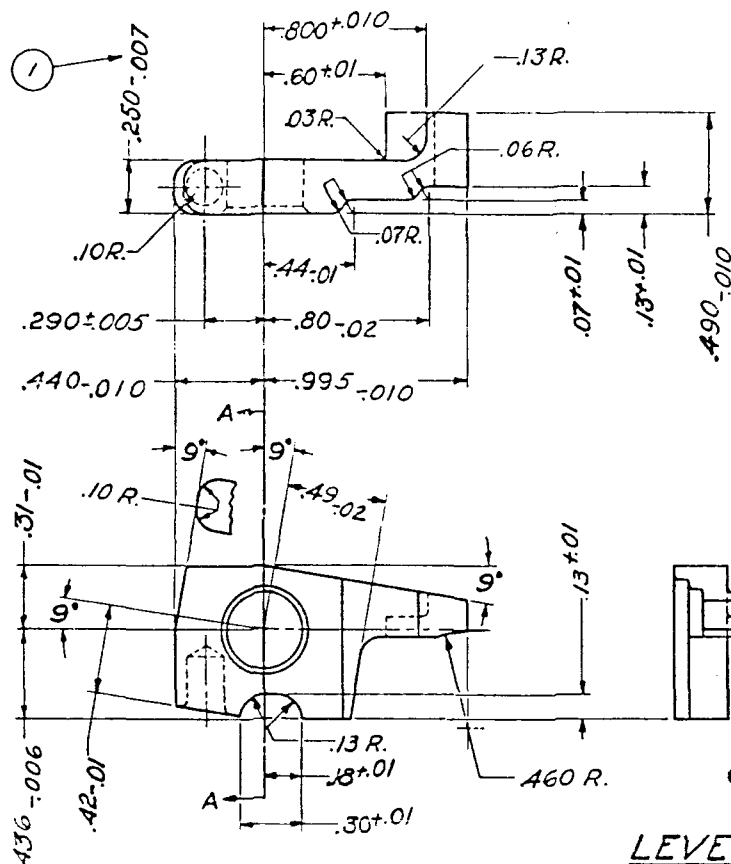
Orlley Sinton
LT COL. ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE.

Johnasuch
COL ORD. DEPT. U. S. A.
ORDNANCE DEPT. U. S. A.

SUPERSEDES B147674

HEAT TREATMENT & FINAL FINISH



LEVER, SEAR (B147675-2)
FINISH "J"

6147675

REF. DRG. A.O.C. A42-34

B6147675

SCALE 2/1

B147675

PHYSICAL PROPERTIES

Y.P.	
T.S.	
EL 2	
RED.	
BR.	
ROCK.	

DEC. 31, 1941
REVISIONS

1	9-30-42		
2	10-9-43		
3	12-30-43		
4	CONVERSION 10-30-51		

DRG. PERTAINS TO

51-63	.45 S.M.G.-M28A1
51-116	.45 S.M.G.-M1
51-124	.45 S.M.G.-M1A1

DFTSMAN	TRACER	L'DG DFTSMAN
W.D.M.	P.A.D.	G.P.T.
CHECKER	50% E.G.W.	CHIEF DFTSMAN

SUBMITTED:
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE.

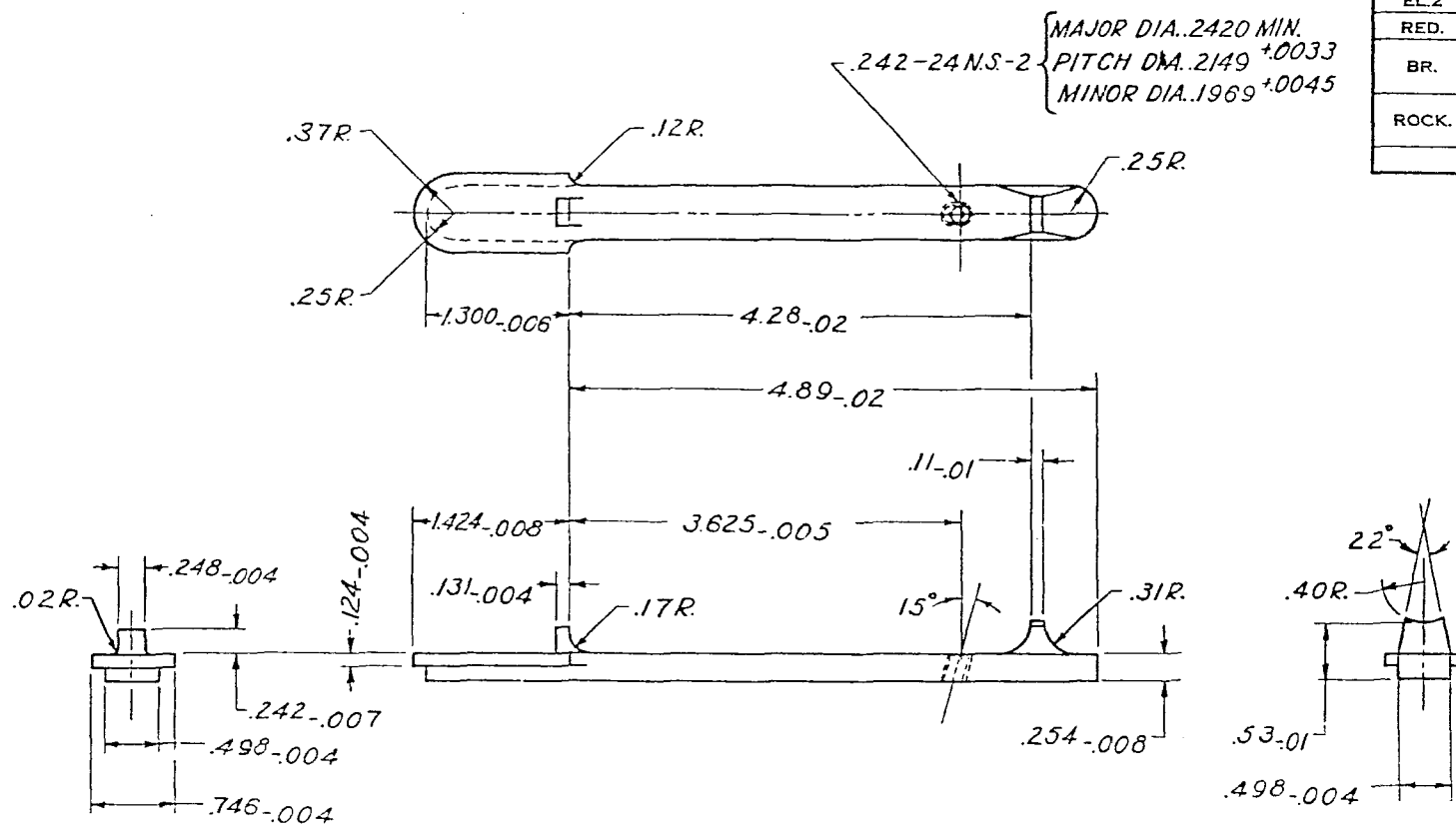
ORDNANCE DEPT., U. S. A.

B6147675

SUPERSEDES B147675

WHERE "BASIC" IS USED, THE FLAT FIGURE, WITHOUT TOLERANCE, WILL BE USED IN COMPUTING ORDNANCE GAGE. TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

HEAT TREATMENT & FINAL FINISH



MOUNT, GRIP (6147676-5 6147676
FINISH "f")

B6147676 SCALE $\frac{1}{1}$

REF. DRG. A.O.C. A 42-10
SPRINGFIELD ARMORY

SUPERSEDES OLD TRACING B147676 UNDER REVISION DATE OF DEC. 30, 1943

~~B 147670~~

PHYSICAL PROPERTIES		DEC. 31, 1942			
		REVISIONS			
Y.P.		5	12-30-45		
T.S.		6	CONVERSION 10-30-51		
EL.2					
RED.					
BR.					
ROCK.					
		DRG. PERTAINS TO			
		51-63	45SMG-M28A1		
		51-116	45SMG-M1		
		51-124	45SMG-M1A1		
		C64386	RECEIVER,		
			W/BARREL, ASM		
		C113656	RECEIVER,		
			W/BARREL, ASM		
		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED			
		DECIMAL ± .01			
		FRACTIONAL ±			
		ANGULAR ±			
		DFTSMAN	TRACER	LOG. DFTSMAN	
		<i>W.C.</i>	<i>W.C.</i>	<i>W.C.</i>	
		CHECKER	<i>E.G.W.</i>	CHIEF DFTSMAN	
		<i>E.G.W.</i>	<i>E.G.W.</i>	<i>E.G.W.</i>	<i>E.G.W.</i>
		SUBMITTED:-			
		<i>Frederick</i> HD. ENG. ORD. DEPT.			
		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:- <i>Robert L. Tucker</i> LT. COL. ORD. DEPT.			
		ORDNANCE DEPT., U.S.A.			

A technical drawing of a bullet tip. It shows a conical shape with a 22-degree angle indicated by an arc and the number '22°'. The drawing is a side view, showing the profile of the bullet. There are some construction lines and a small rectangular base at the bottom.

U.S. A.O.C. A 42-13
 SPRINGFIELD ARMORY

147670

SUPERSEDES B147676

B6147676

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

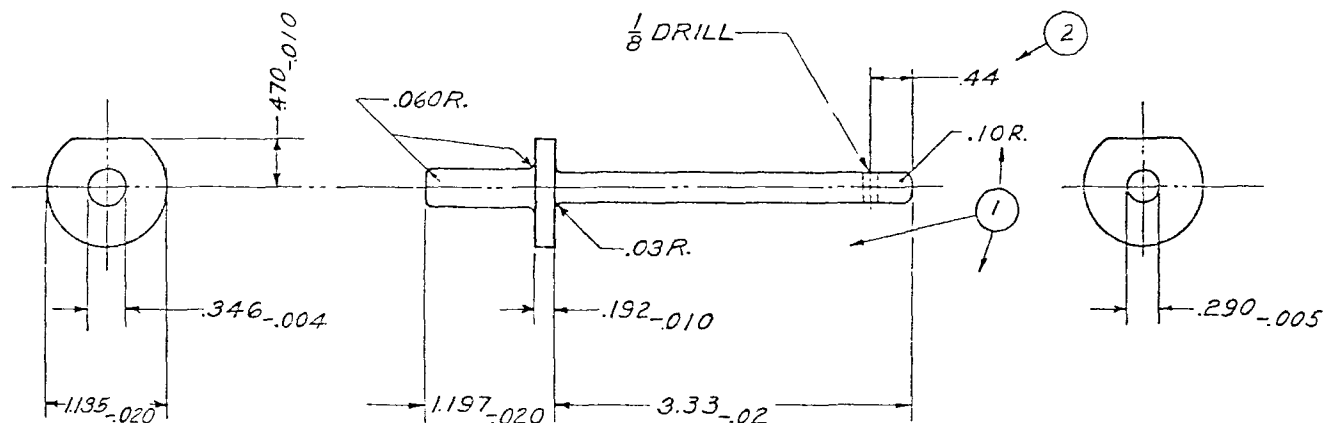
DEC. 31, 1941

REVISIONS

Y.P.		1	8-22-42		
T.S.		2	12-30-43		
EL.2		3	CONVERSION 10-30-51		
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

51-63 455MG-M28A1



PILOT, BUFFER (B147677-2-6147677)
FINISH

1 2

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147677 SCALE $\frac{1}{1}$

REF.DRG. A.O.C. 45-1-21

B147677

DFTSMAN	TRACER	L'DG DFTSMAN
H.M.F.	H.L.M.	C.J.H.
CHECKER	CHIEF DFTSMAN	
E.M.	S.E.G.W.	SA 0.0
SUBMITTED:		
<p>Walter Senter</p> <p>LT. COL. ORD. DEPT. U.S.A.</p> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE.</p> <p>John H. Senter</p> <p>COL. ORD. DEPT. U.S.A.</p> <p>ORDNANCE DEPT. U.S.A.</p>		

CO55050 B147677

B6147677

HEAT TREATMENT & FINAL FINISH

PHYSICAL
PROPERTIES

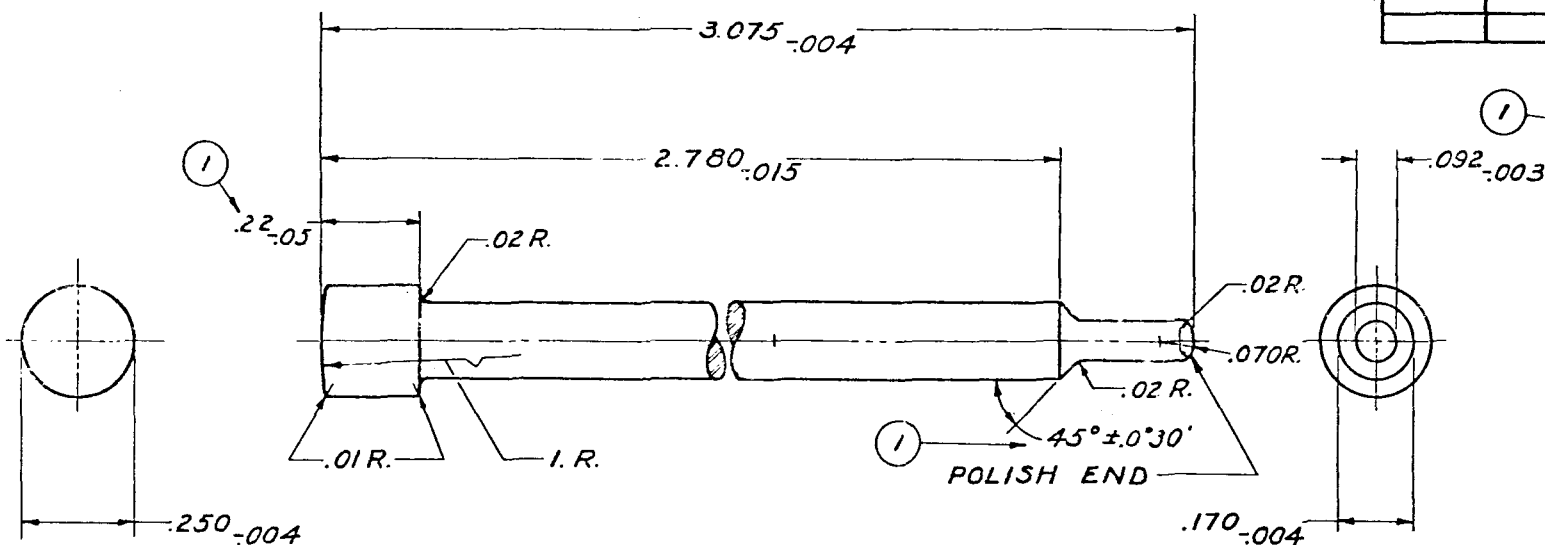
DEC. 31, 1941

REVISIONS

Y.P.	1	9-30-42		
T.S.	2	CONVERSION 10-30-51		
EL.2				
RED.				
BR.				
ROCK.				

DRG. PERTAINS TO

51-63	45 SMG-M28A1
51-116	45 SMG-M1



PIN, FIRING ~~B147678~~ + 6147678
FINISH "f"

TOLERANCE ±.005 ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.

B6147678

SCALE $\frac{4}{1}$

REF. DRG. A.O.C. N42-11

~~B147678~~

DFTSMAN	TRACLR	LOG. DFTSMAN
H.M.F.	H.M.F.	G.P.T.
CHECKER	S.A.	CHIEF DFTSMAN
G.M.	EGW	S.A.

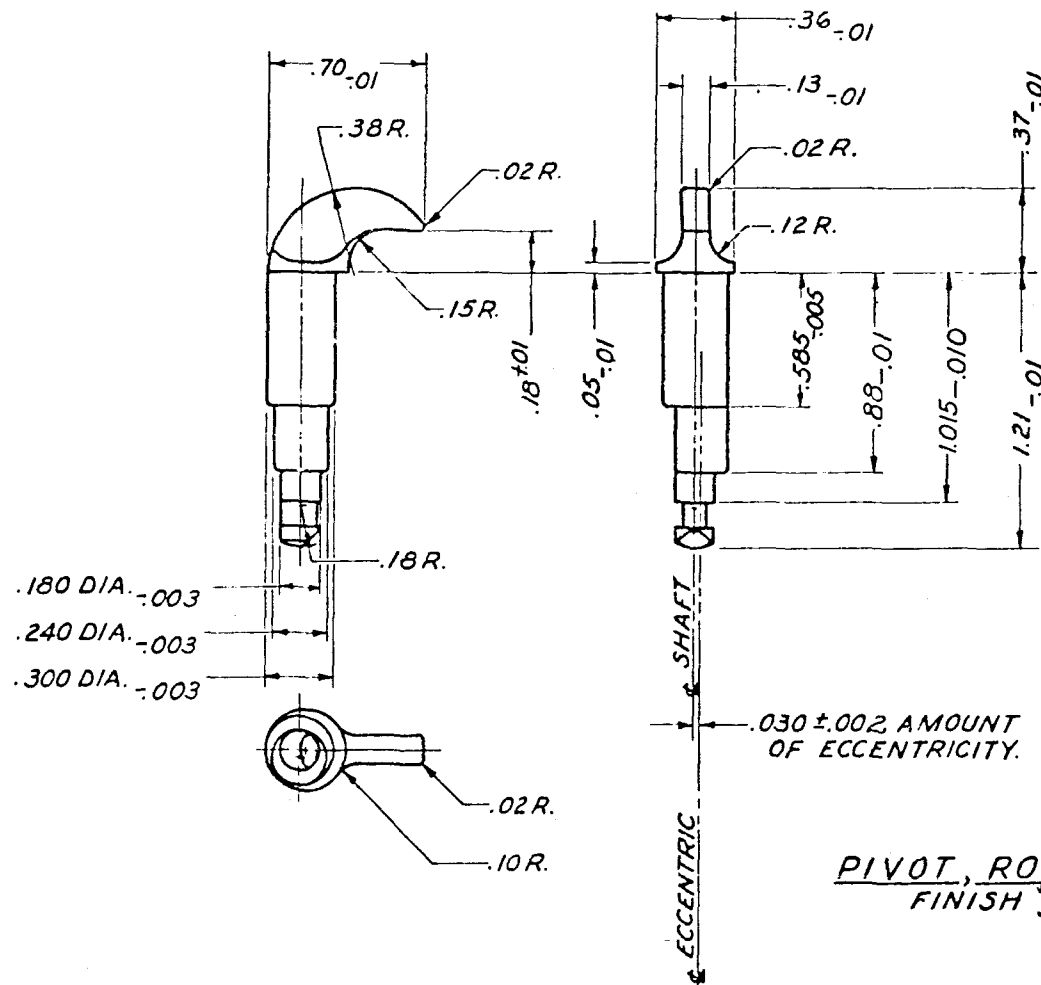
SUBMITTED:-

M. L. G. S.
LT. COL. ORD. DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-
J. H. S.
COL. ORD. DEPT. U. S. A.
ORDNANCE DEPT., U. S. A.

SUPERSEDES B147678

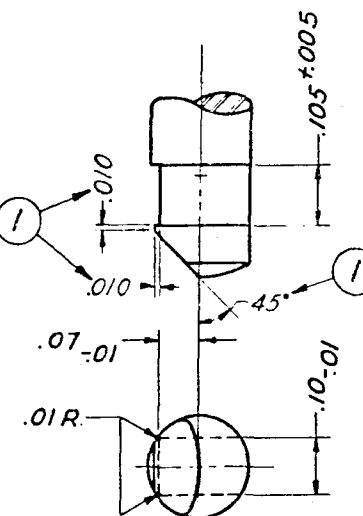
B6147678

HEAT TREATMENT & FINAL FINISH



TOLERANCE ±.005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

PIVOT, ROCKER (B 147679-1)
FINISH "f"



SCALE $\frac{5}{1}$
6147679

SCALE $\frac{2}{1}$

REF. DRG. A.O.C. 45-1-18

B147679 FILE

PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

DEC. 31, 1941

REVISIONS

1	8-30-43		
2	12-30-43		

DRG. PERTAINS TO

51-63 .45 SMG-M28A1

DFTSMAN	TRACER	L'DG. DFTSMAN
H.M.F.	H.M.F.	G.J.G.
CHECKER	S.A.	CHIEF DFTSMAN
G.M.	EGW	SA

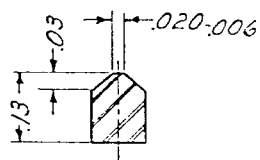
SUBMITTED:

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

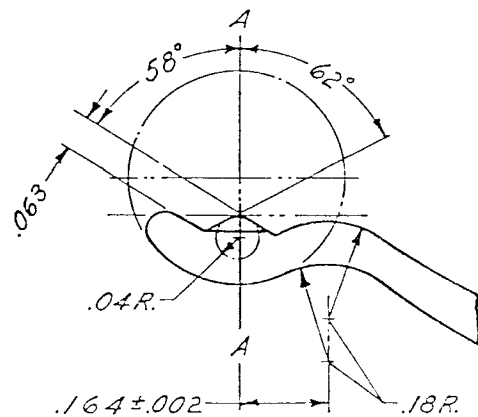
John A. ...
LT. COL. ORD. DEPT. U. S. A.
ORDNANCE DEPT. U. S. A.

HEAT TREATMENT & FINAL FINISH

NOTE: FINGER TO GIVE A TENSION OF 8 TO 12 LBS. FOR A DEFLECTION OF .06 IN.

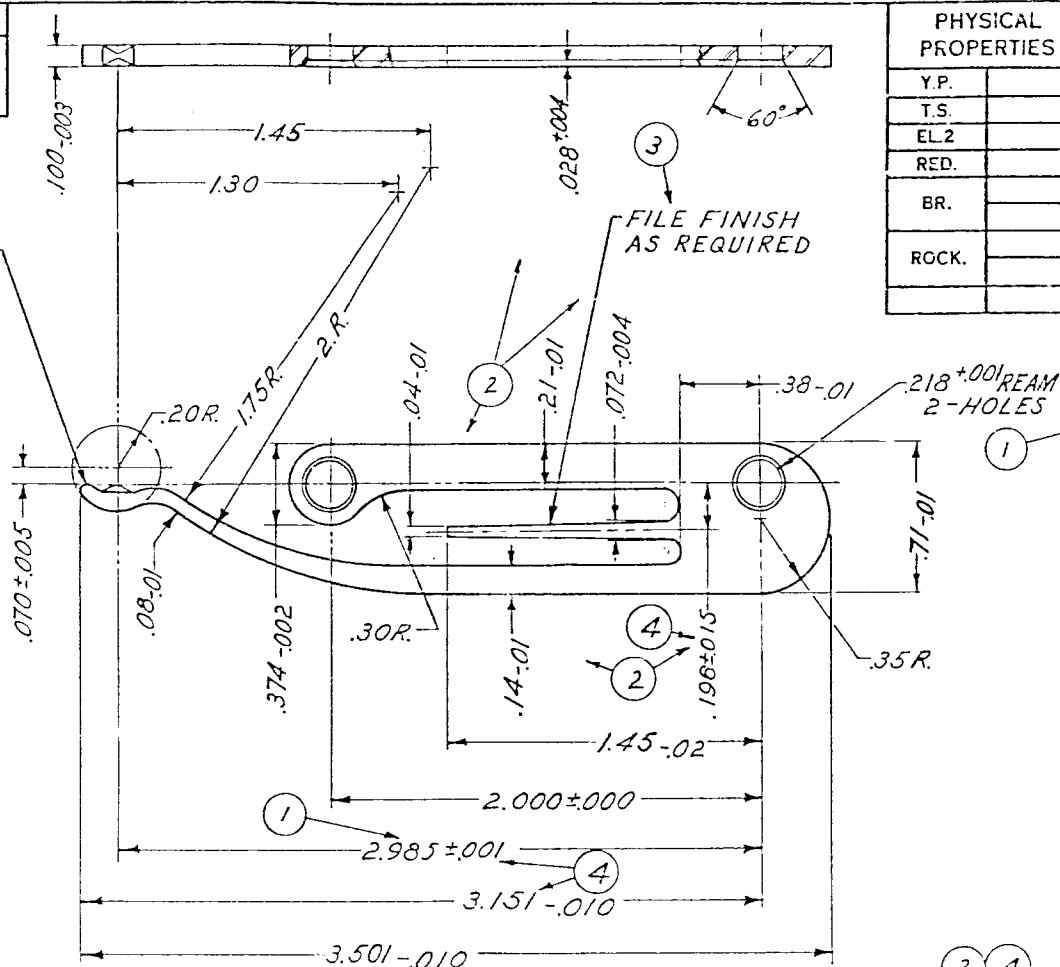


SECTION A-A
SCALE $\frac{5}{1}$



SCALE $\frac{5}{1}$

TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



PLATE, PIVOT (B147680-4)
FINISH "F"
MANUFACTURING COMPONENT 6147680

SCALE $\frac{2}{1}$

B6147680

REF. A.O.C. A42-24

B147680

PHYSICAL PROPERTIES

Y.P.	
T.S.	
EL.2	
RED.	
BR.	
ROCK.	

DEC. 31, 1941

REVISIONS

1'	9-30-42	
2'	9-30-43	
3'	10-9-43	
4'	12-30-43	
5	CONVERSION 10-50-51	

DRG. PERTAINS TO

51-63	.45 SMG-M28A1
B147690	PLATE, PIVOT, ASM
51-116	.45 SMG-M1
51-124	.45 SMG-M1A1

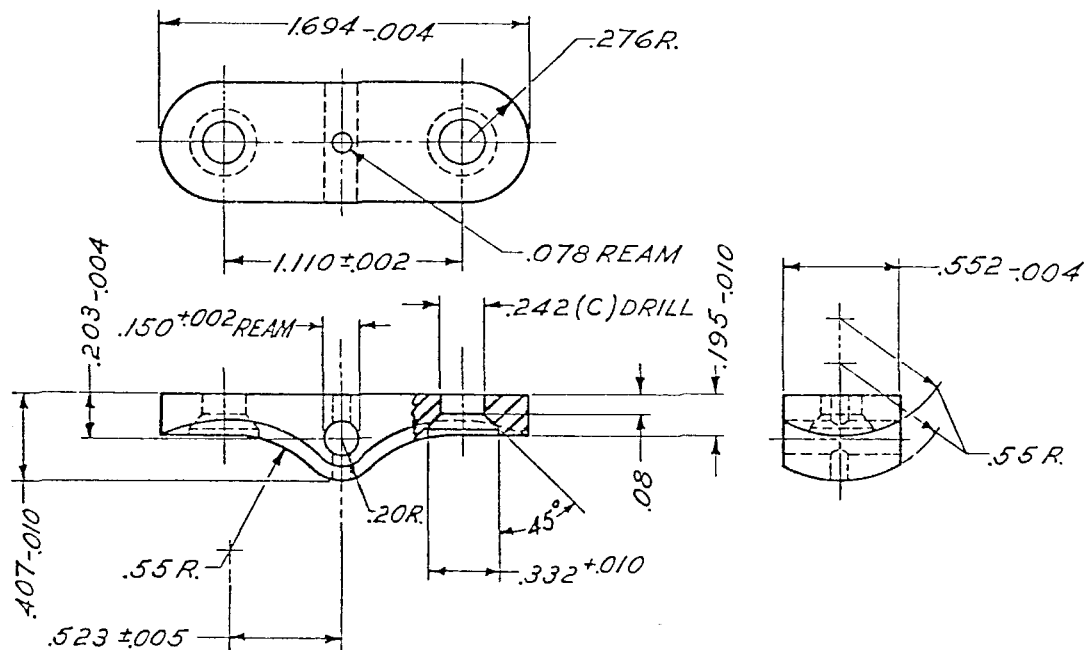
DFTSMAN	TRACER	L'DG DFTSMAN
D.P.	D.P.	G.P.T.
CHECKER	3.E.G.W.	SA 00

SUBMITTED: *Walter E. Smith*
LT. COL. ORD. DEPT. U.S.A.
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

John W. Smith
COL. ORD. DEPT. U.S.A.
ORDNANCE DEPT. U.S.A.

SUPERSEDES B147680

HEAT TREATMENT & FINAL FINISH



PLATE, SLING SWIVEL (B147681 6147681)
FINISH "f"
MANUFACTURING COMPONENT

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

B6147681

SCALE $\frac{2}{1}$

REF. DRG. A.O.C. 45-1-24

B147681

PHYSICAL PROPERTIES

DEC. 31, 1941
REVISIONS

Y.P.		1	CONVERSION 10-30-51		
T.S.					
EL.2					
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

51-63 45SMG-ME3A1
B147692 SWIVEL, SLING,
ASSEMBLY

DFT. MAN. TRACER L'DG. DFTSMAN
W.I.K. D.J. C.J.T.

CHECKER CHIEF DFTSMAN
C.M. E.G.W. S.A. O.O.

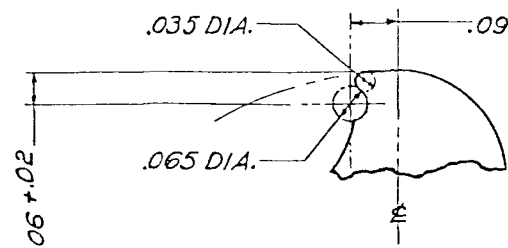
SUBMITTED:

LT. COL. ORD. DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:

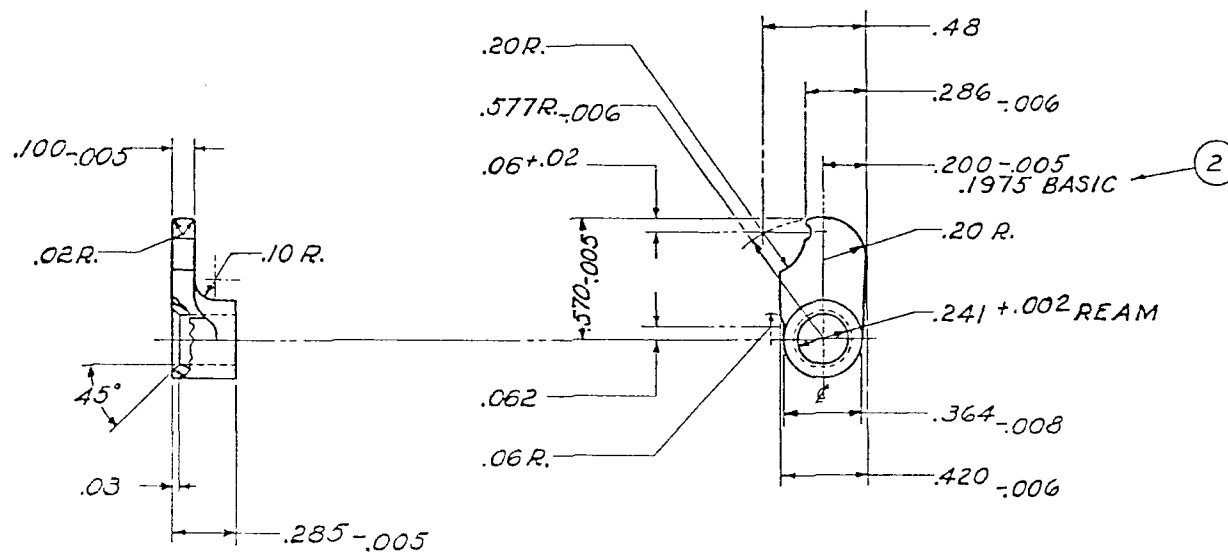
John R. Smith
COL. ORD. DEPT. U. S. A.
ORDNANCE DEPT. U. S. A.

B6147681

HEAT TREATMENT & FINAL FINISH



ENLARGED DETAIL OF ROCKER END
SCALE $\frac{5}{1}$



PHYSICAL PROPERTIES		DECEMBER 31, 1941.	
		REVISIONS	
Y.P.		1	9-30-42
T.S.		2	12-30-43
EL 2		3	CONVERSION 10-30-51
RED.			
BR.			
ROCK.			

DRG. PERTAINS TO

51-63	.45 SMG-M28 A1
51-116	.45 SMG-M1
51-124	.45 S.M.G.-M1A1

DFTSMAN R.B.	TRACER R.B.	L'DG. DFTSMAN B.F.T.
CHECKER C.H.	SA E.G.W.	CHIEF DFTSMAN SA G.A.

SUBMITTED: *[Signature]*
LT. COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE: *[Signature]*
COL. ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

WHERE "BASIC" IS USED, THE FLAT FIGURE, WITHOUT TOLERANCE, WILL BE USED IN COMPUTING ORDNANCE GAGE. TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

ROCKER ~~B147682~~ 6147682
FINISH

B6147682

SCALE $\frac{2}{1}$

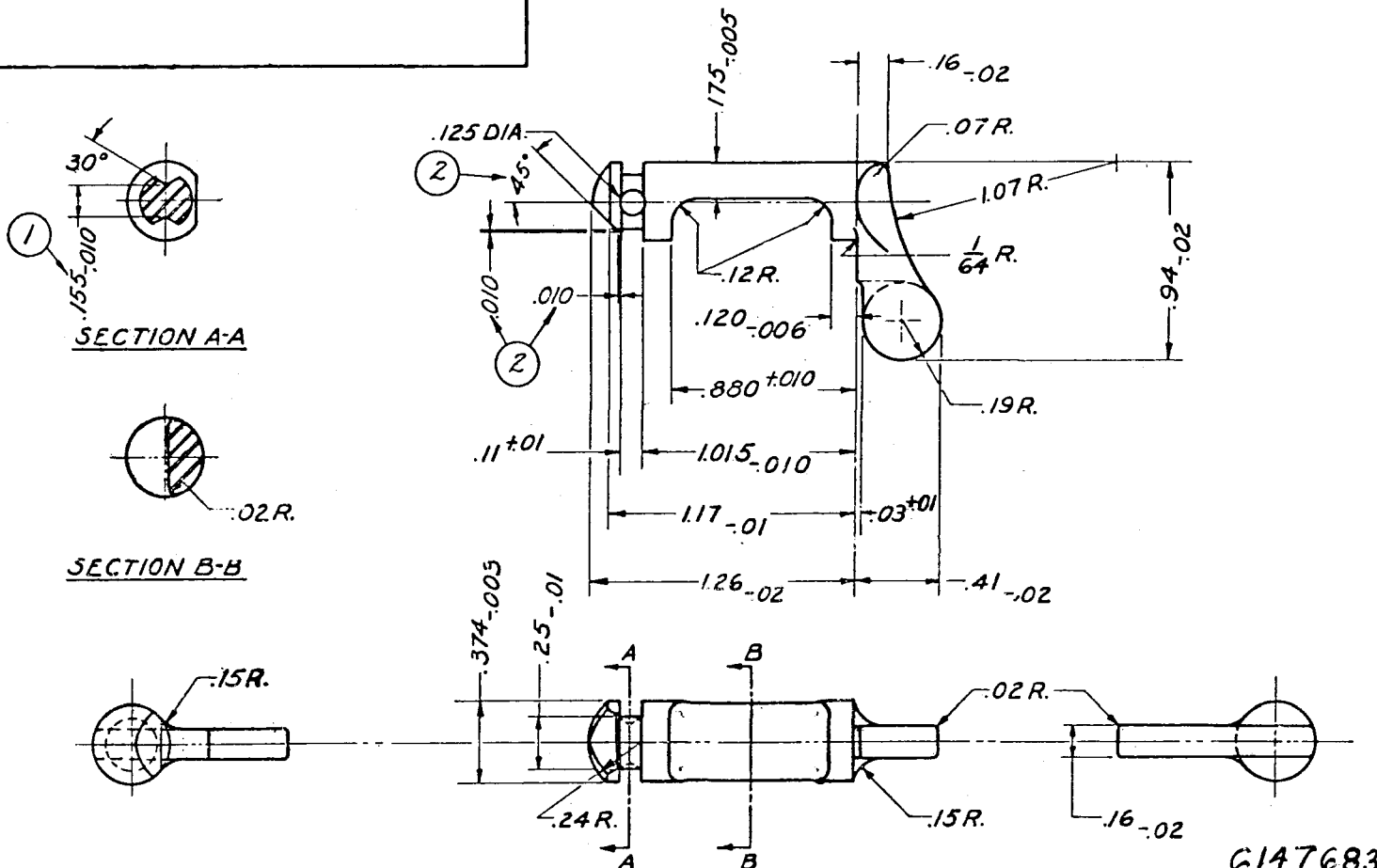
REF. A-O.CO.DRG. 45-1-18

~~B147682~~

SUPERSEDES B147682

B6147682

HEAT TREATMENT & FINAL FINISH



SAFETY FINISH (B) 147683-2

6147683

(1) (2)

TOLERANCE ± .005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE 2/1

REF. DRG. A.O.C. 45-1-7

B 147683

PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

DEC. 31, 1941

REVISIONS

1st 4-30-43
2nd 8-30-43
3 12-30-43

DRG. PERTAINS TO

51-63 45 SMG-M28 A1

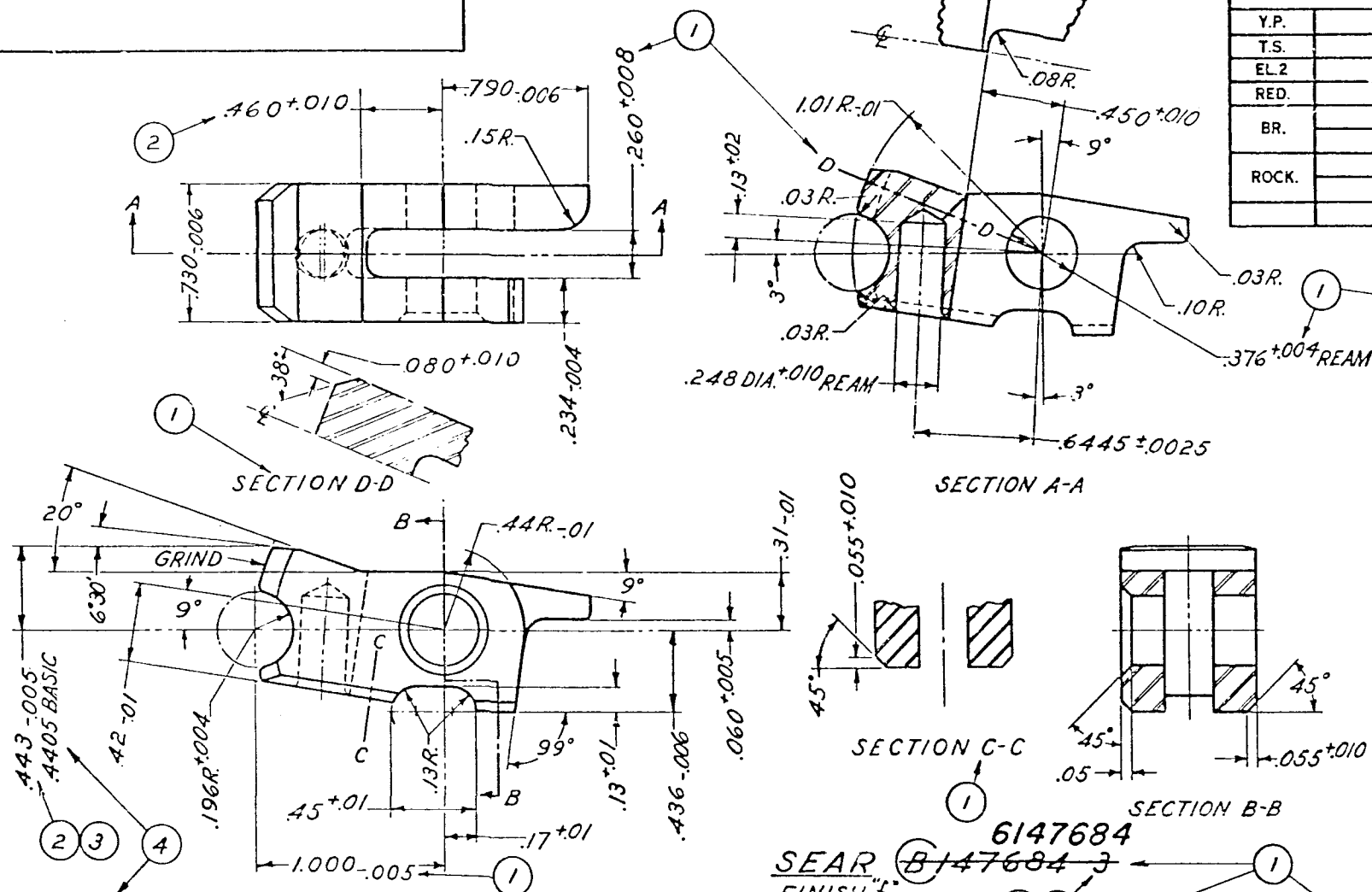
DFTSMAN TRACER L'DG. DFTSMAN
W.S.M. H.M.F. G.P.F.
CHECKER S.A. CHIEF DFTSMAN
G.M. E.G.W. S.A. O.O.

SUBMITTED:
LT. COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

ORDNANCE DEPT., U. S. A.

OBSOLETE

HEAT TREATMENT & FINAL FINISH



WHERE "BASIC" IS USED, THE FLAT FIGURE, WITHOUT TOLERANCE, WILL BE USED IN COMPUTING ORDINANCE GAGE. TOLERANCE ± 0.005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

PHYSICAL PROPERTIES		DEC. 31, 1941			
		REVISIONS			
Y.P.		1 st	9-30-42		
T.S.		2 nd	7-28-43		
EL. 2		3 rd	10-9-43		
RED.		4 th	12-30-43		
BR.		5	CONVERSION 10-30-51		
ROCK.					

DRG. PERTAINS TO

51-63	.45 S&W M28A1
51-116	.45 S&W M1
51-124	.45 S.M.G. MIA

OFFSMAN <i>D.P.</i>	TRACER <i>D.P.</i>	LOG OFFSMAN <i>C.P.H.</i>
CHECKER <i>C.M.</i>	<i>ECW</i> <i>ECW</i>	CHIEF OFFSMAN <i>SA</i>

SUBMITTED:-

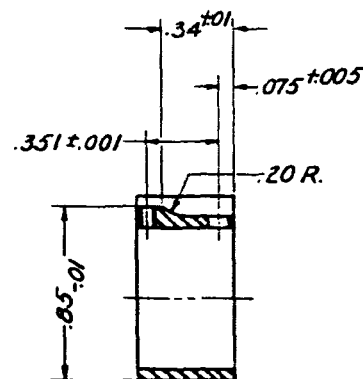
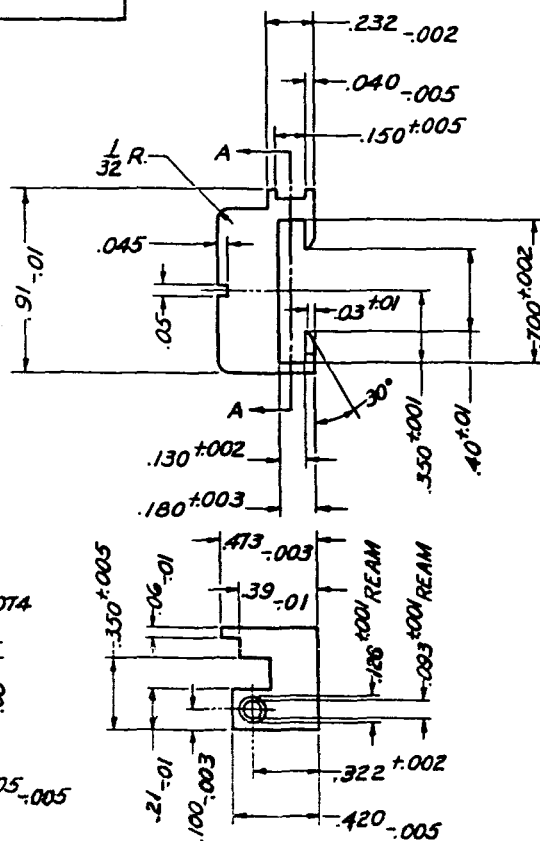
Walter Banta
LT. COL., ORD. DEPT. U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

John A. M. C.
COL. ORD. DEPT. U. S. A.
ORDNANCE DEPT. U. S. A.

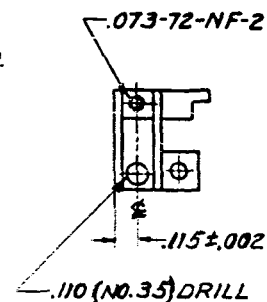
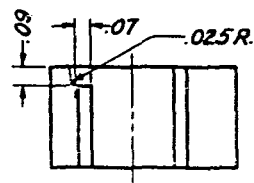
SUPERSEDES B147684

B6147684

HEAT TREATMENT & FINAL FINISH



SECTION A-A



SLIDE, REAR SIGHT ~~B 147685~~ 6147685
FINISH J

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

6147685

SCALE $\frac{2}{1}$

REF. DRG. AQC. 45-7-2

~~B 147685~~

PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1	CONVERSION 10-30-51
T.S.			
EL. 2			
RED.			
BR.			
ROCK.			

DRG. PERTAINS TO

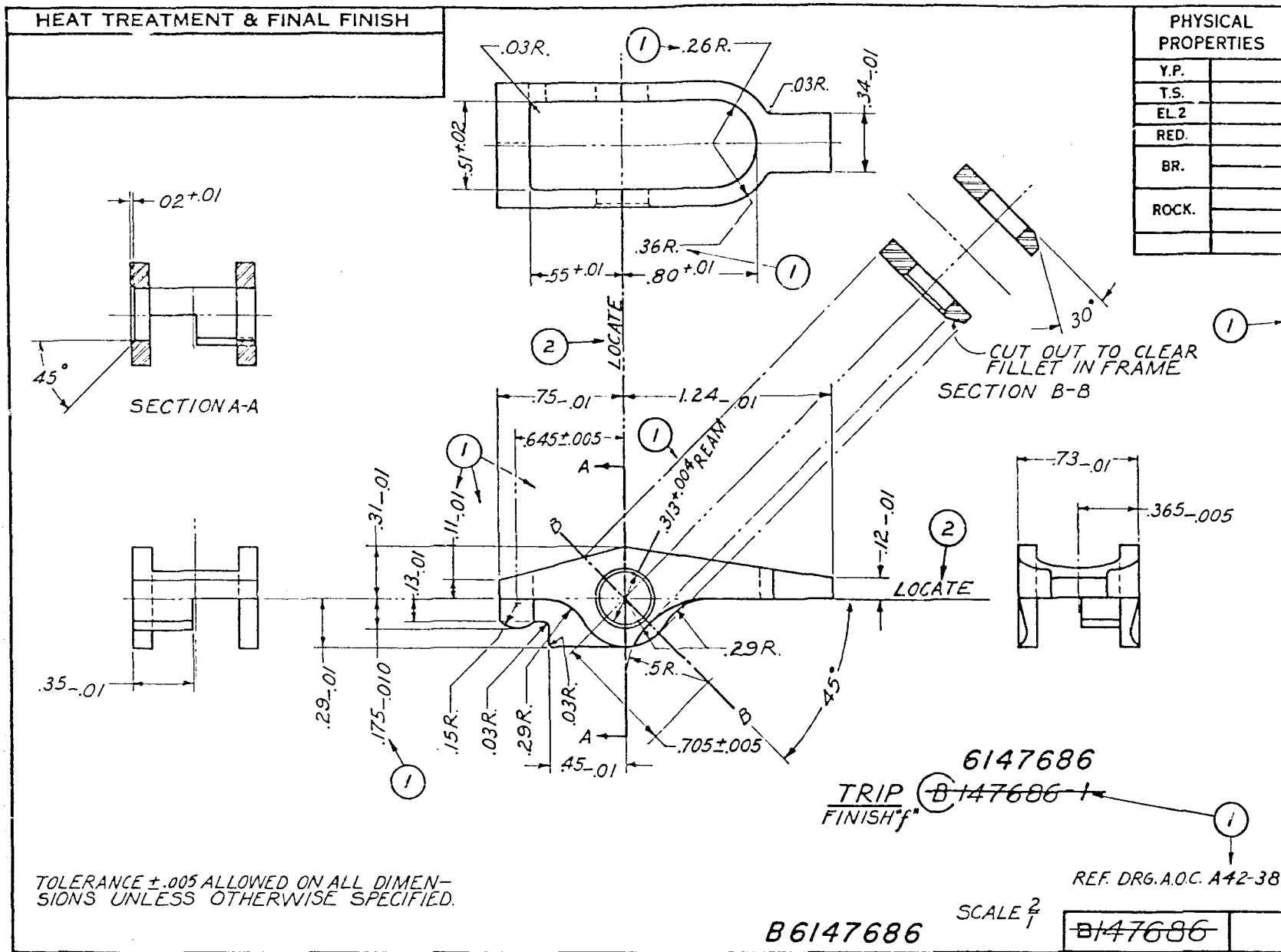
51-63 .45 SMG-M28 A1
CGA382 LEAF, REAR SIGHT, AS

DFTSMAN	TRACER	L'DG. DFTSMAN
H.P.	H.M.F.	G.H.
CHECKER	SAO	CHIEF DFTSMAN
B.M.	EGW	J.M.
SUBMITTED:		
J.W. Miller		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:		
W. Moore		
LT. COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT., U. S. A.		

SUPERSEDES 3147685

B6147685

HEAT TREATMENT & FINAL FINISH



PHYSICAL PROPERTIES		DEC. 31, 1941	
		REVISIONS	
Y.P.		1	9-30-42
T.S.		2	12-30-43
EL 2		3	CONVERSION 10-30-51
RED.			
BR.			
ROCK.			

DRG. PERTAINS TO

51-63	45SMG-M28A1
51-116	45SMG-M1
51-124	45SMG-M1A1

OFFSMAN	TRACER	L'DG OFFSMAN
66B	66B	G.f.t.
CHECKER	EGW	CHIEF OFFSMAN
66B	EGW	S.A. O.O.

SUBMITTED:

 LT. COL. ORD. DEPT., U.S.A.
 APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

COL. ORD. DEPT., U.S.A.
 ORDNANCE DEPT., U.S.A.

6147686
 TRIP (B) 6147686-1
 FINISH

REF. DRG. A.O.C. A42-38

SCALE 2/7

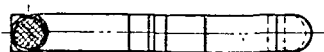
B6147686

B147686

SUPERSEDES B147686

PC147686

HEAT TREATMENT & FINAL FINISH



BUTTON-A 152984

SWEDGE BUTTON HERE

CATCH-A 152985

LIST OF COMPONENTS

1 LINE NUMBER	2 DRAWING NUMBER OR PIECE MARK	3 NAME OF COMPONENT	NO REQUIRED PER UNIT ASM.
1	B147687	CATCH, BUTT STOCK, ASSEMBLY	1
2		COMPOSED OF:	
3	A152984	1-BUTTON, BUTT STOCK CATCH	*
4	A152985	1-CATCH, BUTT STOCK	*

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



PHYSICAL PROPERTIES		DEC. 31, 1941 REVISIONS			
Y.P.		1	12-30-43		
T.S.		2	CONVERSION 10-30-51		
EL.2					
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

51-63 45 SMG-M28A1
C64387 STOCK, ASSEMBLY

6147687
CATCH, BUTT STOCK, ASSEMBLY (B147687)

DFTSMAN	TRACER	LDG DFTSMAN
H.M.F.	H.M.F.	G.J.F.
CHECKER	S.A.	CHIEF DFTSMAN
E.M.	W.C.	E.J.

SUBMITTED:

W.C. E.M.
LT COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:

J. H. Smith
COL. ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

B6147687
REF. DRG. A.O.C. 45-62

B147687

SUPERSEDES B147687

B6147687

PHYSICAL PROPERTIES		DEC. 31, 1941.					
		REVISIONS					
Y.P.	.	/	CONVERSION 10-30-51				
T.S.							
EL 2							
RED.							
BR.							
ROCK.							

DRG. PERTAINS TO

51-63 45 SMG-M28 A1

C64382 LEAF, REAR SIGHT ASSEMBLY

6147688

~~6147688~~

DFTSMAN	TRACER	L'DG. DFTSMAN
H.M.F.	P.K.V.	E.J.O.
CHECKER	FL SA EGW	CHIEF DFTSMAN
E.G.W.		J.H. W

SUBMITTED:

8/4/41 / Major Entin

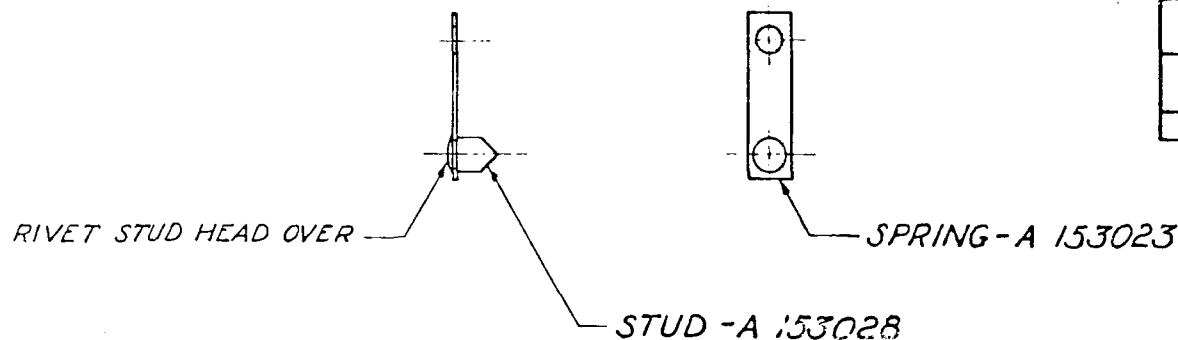
LT COL. ORD DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORNANCE:-

W.L. Moore

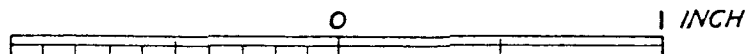
LT. COL. ORD DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.



LIST OF COMPONENTS.			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	B147688	CATCH, REAR SIGHT SLIDE, ASSEMBLY	1
2		COMPOSED OF :-	
3	A 153023	1- SPRING, REAR SIGHT SLIDE CATCH	*
4	A 153028	1- STUD , REAR SIGHT SLIDE CATCH	*

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



B6147688
REF. DRG. A.O.C. 45-7-3

~~B/47688~~

SUPERSEDES B147688

B6147689

HEAT TREATMENT & FINAL FINISH

PHYSICAL
PROPERTIES

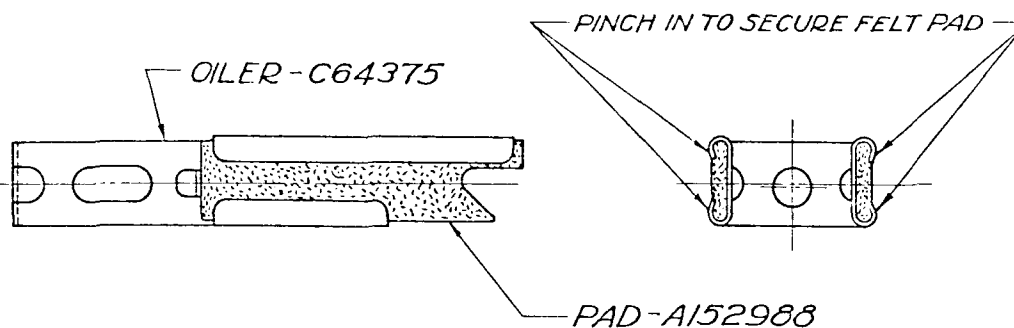
DEC. 31, 1941

REVISIONS

Y.P.		1	CONVERSION 10-30-51		
T.S.					
EL. 2					
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

51-63 455MG-M28A1



LIST OF COMPONENTS

1 LINE NUMBER	2 DRAWING NUMBER OR PIECE MARK	3 NAME OF COMPONENT	4 NO. REQUIRED PER UNIT
1	B147689	OILER, BREECH, ASSEMBLY	1
2		COMPOSED OF:	
3	C64375	1-OILER, BREECH	*
4	A152988	2-PAD, BREECH OILER	*

6147689
OILER, BREECH, ASSEMBLY (B147689-

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



REF. DRG. A.O.C. 45-1-8

B147689

DFTSMAN	TRACER	LOG. DFTSMAN
H.M.F.	M.E.K.	C. J. H.
CHECKER	100%	CHIEF DFTSMAN
C.H.	E. G. W.	J. H.

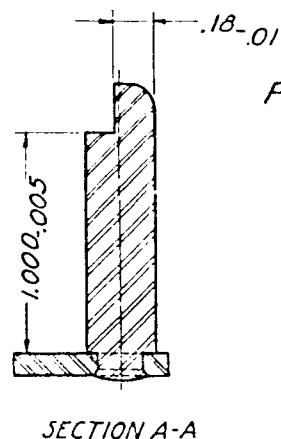
SUBMITTED:

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

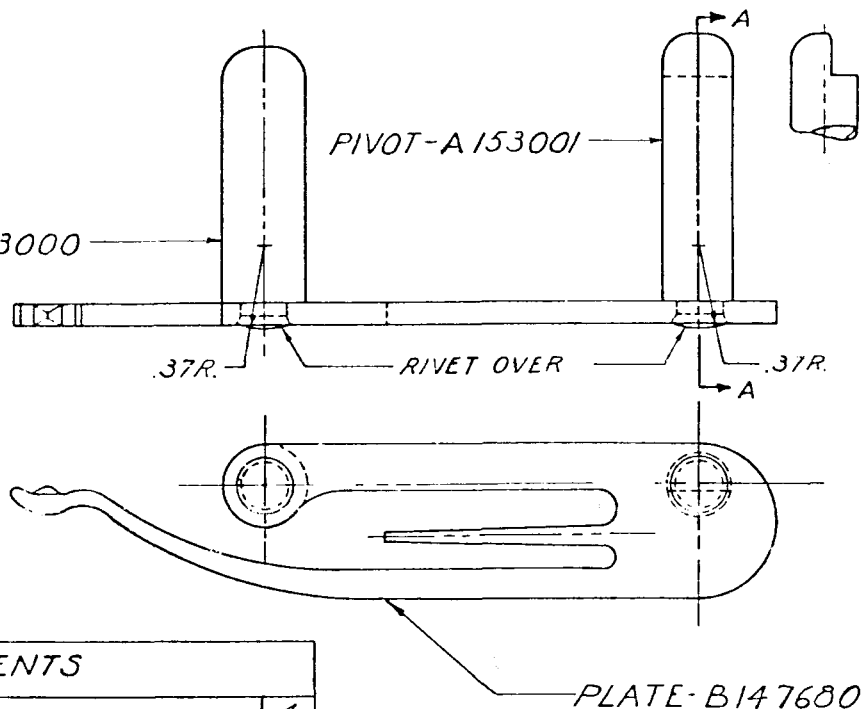
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

SUPERSEDES B147689

HEAT TREATMENT & FINAL FINISH



PIVOT - A 153000



LIST OF COMPONENTS

1 LINE NUMBER	2 DRAWING NUMBER OR PIECE MARK	3 NAME OF COMPONENT	4 NO. REQUIRED PER UNIT ASM.
1	B147690	PLATE, PIVOT, ASSEMBLY	1
2		COMPOSED OF:	
3	A 153000	1- PIVOT, SEAR	*
4	A 153001	1- PIVOT, TRIGGER	*
5	B 147680	1- PLATE, PIVOT	*

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.
TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

DEC. 31, 1941

REVISIONS

1 9-30-42
2 9-30-43
3 CONVERSION
10-30-51

DRG. PERTAINS TO

51-63 45 S.M.G. M2BAI
51-116 45 S.M.G. MI
51-124 45 S.M.G. MIAI

6147690
PLATE, PIVOT, ASSEMBLY (B147690-2)

B6147690

REF. DRG. A.O.C. A 42-89

B147690

DFTSMAN TRACER LOG DFTSMAN
CHECKER CHIEF DFTSMAN
SUBMITTED:

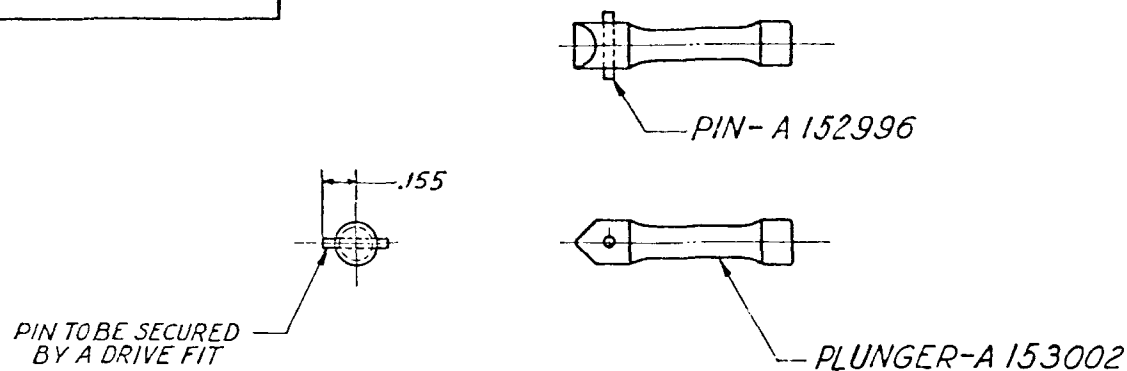
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE.

ORDNANCE DEPT. U. S. A.

SUPERSEDES B147690

B6147690

HEAT TREATMENT & FINAL FINISH

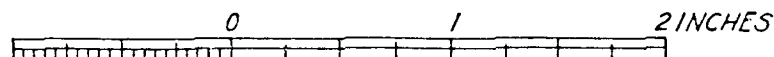


LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO REQUIRED PER UNIT ASM
1	B147691	PLUNGER, REAR SIGHT LEAF, ASSEMBLY	1
2		COMPOSED OF:-	
3	A152996	1- PIN, SIGHT PLUNGER	*
4	A153002	1- PLUNGER, SIGHT	*

6147691
PLUNGER, REAR SIGHT LEAF, ASSEMBLY

*WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES. B6147691



REF. DRG. A.O.C. 45-7-3

B147691

PHYSICAL PROPERTIES		DECEMBER 31, 1941 REVISIONS			
Y.P.		1	CONVERSION 10-30-51		
T.S.					
EL. 2					
RED.					
BR.					
ROCK.					

DRG. PERTAINS TO

51-63 .45SMG-M28A1

DFTSMAN	TRACER	L'DG DFTSMAN
H.M.F.	A.I.D.	G.F.T.
CHECKER	W.B. 0%	CHIEF DFTSMAN
E.M.	W.B. 0%	W.B. 0%

SUBMITTED: *W.B. 0%*

LT. COL. ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

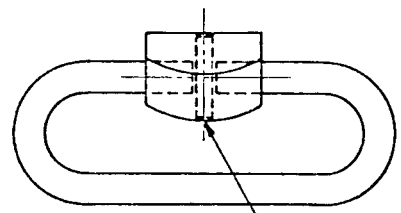
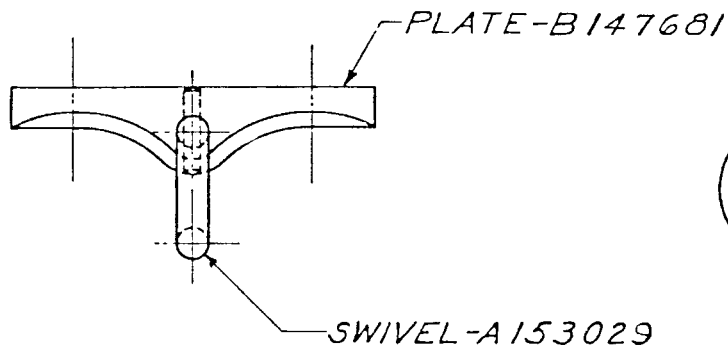
W. Moore
LT. COL. ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

SUPERSEDES B147691

B6147691

B6147692

HEAT TREATMENT & FINAL FINISH



PHYSICAL PROPERTIES		DEC. 31, 1941 REVISIONS			
Y.P.		1	CONVERSION 0-30-57		
T.S.					
EL.2					
RED.					
BR.					
ROCK.					

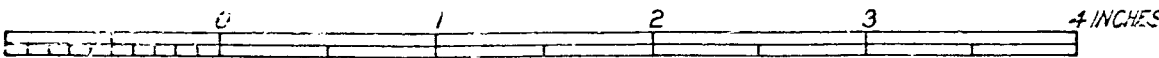
DRG. PERTAINS TO

51-63	.45 S.M.G.-M28A1
C64301	GRIP, FORE, HORI-
	ZONTAL, ASSEMBLY
C64307	STOCK, ASSEMBLY

LIST OF COMPONENTS			
1 LINE NUMBER	2 DRAWING NUMBER OR PIECE MARK	3 NAME OF COMPONENT	4 NO. REQUIRED PER UNIT
1	B147692	SWIVEL, SLING, ASSEMBLY	2
2		COMPOSED OF:-	
3	A152998	1-PIN, SLING SWIVEL	*
4	B147681	1-PLATE, SLING SWIVEL	*
5	A153029	1-SWIVEL, SLING	*
6			
7			

SWIVEL, SLING, ASSEMBLY (B147692) 6147692

* SHALL NOT BE ISSUED FOR FIELD MAINTINANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



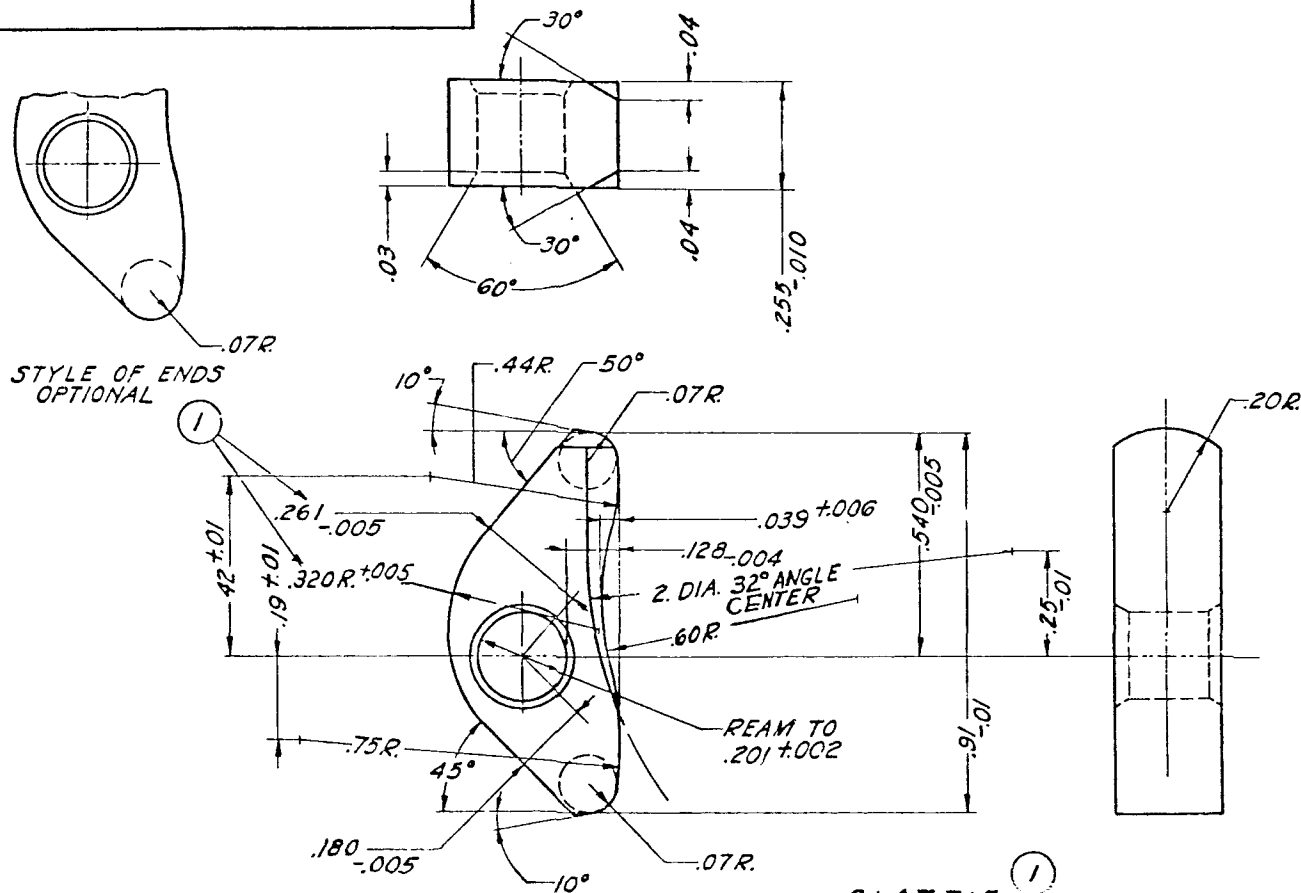
B6147692
REF. DRG. A.O.C.451-24

6147692

OFFSMAN W.L.M.	TRACER W.L.M.	LDG. OFFSMAN C.F.H.
CHECKER C.H.	SA E.G.W.	CHIEF OFFSMAN J.A.
SUBMITTED:-		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-		
J. L. J. J.		
COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT., U. S. A.		

SUPERSEDES B147692

HEAT TREATMENT & FINAL FINISH



HAMMER
FINISH

6147715

6147715

REF. DRG. A.O.C. N42-19
SPRINGFIELD ARMORY

TOLERANCE \pm .01 ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.

6147715

SCALE: $\frac{4}{1}$

6147715

PHYSICAL
PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

APRIL 30, 1942

REVISIONS

1² 10-9-43
2 CONVERSION
10-30-51

DRG. PERTAINS TO

51-116 45 SMG-M1

DFTSMAN <i>Quil</i>	TRACER <i>Quil</i>	L'DG. DFTSMAN <i>E.P.T.</i>
CHECKER <i>E.G.W.</i>	CHEF DFTSMAN <i>E.P.T.</i>	O.D.
SUBMITTED: <i>E. Ambrose</i>		
2RD. ENG. ORD. DEPT. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>W. L. ...</i> CO. ORD. DEPT.		

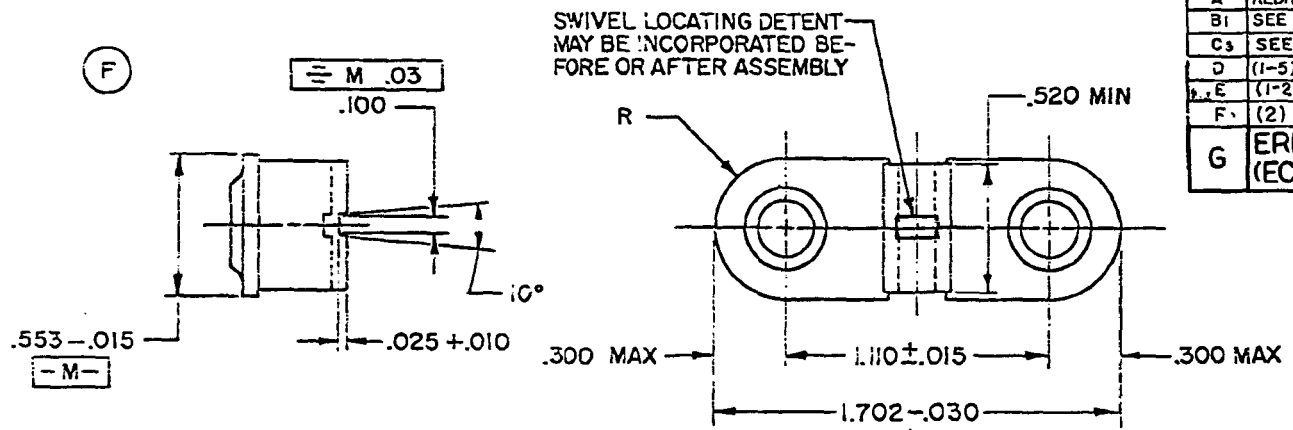
ORDNANCE DEPT., U. S. A.

SUPERSEDES B147715

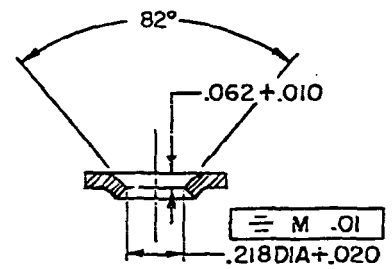
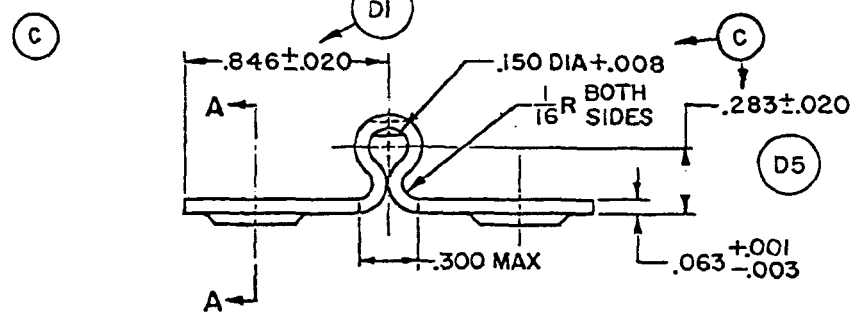
B6147715

B6147716

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
2		10-30-51	
A	REDRAWN AND REVISED, SEE EO SA 24435	15 JAN 58	<i>[Signature]</i>
B1	SEE EO NO. SA 25395	16 OCT 59	<i>[Signature]</i>
C3	SEE EO NO. SA 25915	23 NOV 60	<i>[Signature]</i>
D	(1-5) SEE EO NO. SA 27712	30 OCT 64	<i>[Signature]</i>
E	(1-2) SEE EO 82000	5 FEB 68	<i>[Signature]</i>
F	(2) SEE ERR HQR 30602	8 JAN 73	<i>[Signature]</i>
G	ERR Z9Z11698 (ECP W9S2019/790629)	891016	ORCL-CNT



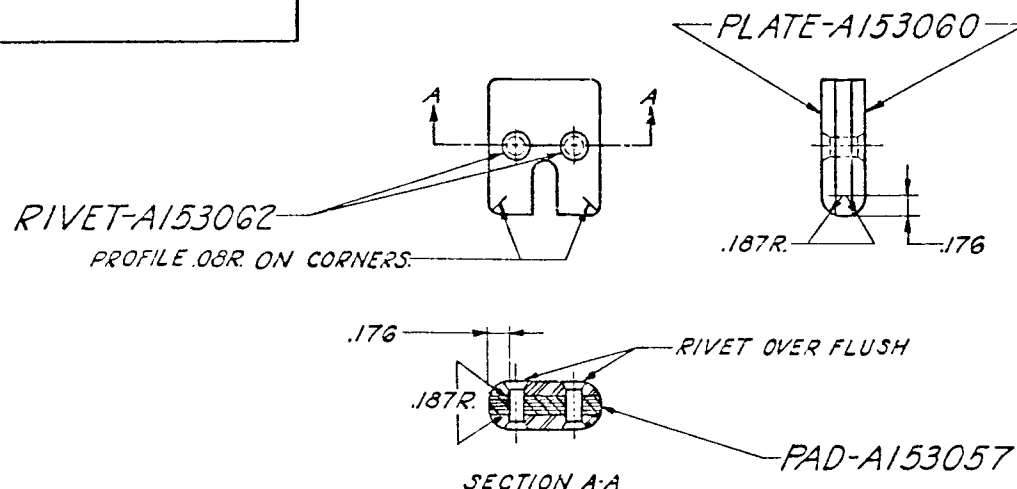
- NOTES:
1. FINAL PROTECTIVE FINISH:
FINISH 5.3.1.2 OF MIL-STD-171
 2. EXCEPT FOR .150 DIA+.008
DIMENSIONS APPLY AFTER ASSY
WITH SWIVEL B5153029
 3. MATERIAL:
STEEL, SPEC QQ-S-698, CR
NO. 4. TEMPER: CARBON .12 TO .24
 4. 250° EDGES ONLY
 5. BREAK EDGES .005+.015
 6. MIL-W-13855 APPLIES.



SECTION A-A

<p>LAUNCHER</p> <p>B6147721 M 79</p>		<p>PHYSICAL PROPERTIES</p> <p>YP</p> <p>TS</p> <p>EL2</p> <p>RA</p> <p>BH</p> <p>RH</p>	<p>UNLESS OTHERWISE SPECIFIED</p> <p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES ON</p> <p>FRACTIONS DECIMALS ANGLES</p> <p>±1/64 ±.010 ±1°</p> <p>MATERIAL</p> <p>SEE NOTE 3</p> <p>HEAT TREATMENT</p> <p>FINAL PROTECTIVE FINISH</p> <p>SEE NOTE 1</p>	<p>ORIGINAL DATE OF DRAWING 30 APR 42</p>		<p>PLATE, SLING SWIVEL</p>	<p>SPRINGFIELD ARMORY, SPRINGFIELD, MA 01101</p>
				<p>DRAFTSMAN R.E.K. CHECKER</p> <p>TRACER R.E.K. CHECKER C.R.C.</p> <p>ENGR R.E.A. ENGR N.W.G.</p> <p>SUBMITTED</p> <p>N.W. GRANT</p> <p>DAO CORPS</p>			
<p>DO NOT APPLY PART NO. AS SPECIFIED</p>				<p>APPROVED BY ORDER OF THE CHIEF OF DR OFFICE</p> <p>H.F. LYNCH</p> <p>CHD CORPS</p>		<p>CODE IDENT NO. 19205</p>	<p>DWG SIZE B</p>
				<p>SCALE 2/1</p>		<p>UNIT WT</p>	<p>SHEET 1 OF 1</p>

HEAT TREATMENT & FINAL FINISH



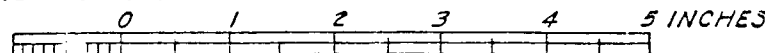
LIST OF COMPONENTS

1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASSEMBLY
1	B147718	BUFFER ASSEMBLY	1
2		COMPOSED OF:-	
3	A153057	1-PAD, BUFFER	*
4	A153060	2-PLATE, BUFFER	*
5	A153062	2-RIVET, BUFFER	*
6			

6147718
BUFFER, ASSEMBLY ~~B147718~~

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



PHYSICAL PROPERTIES

Y.P.
T.S.
EL.2
RED.
BR.
ROCK.

APRIL 30, 1942

REVISIONS

DRG. PERTAINS TO

51-116 .45 S.M.G.-M1
51-124 .45 S.M.G.-M1A1

DFTSMAN TRACER L.D.G. DFTSMAN
CHECKER
SUBMITTED:

B6147718

REF. LOC. A.O.C. A5A-III
SPRINGFIELD ARMORY

~~B147718~~

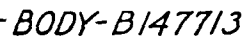
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

ORDNANCE DEPT., U.S.A.

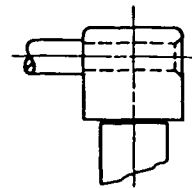
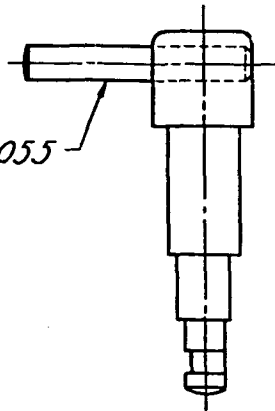
SUPERSEDES B147718

B6147718

HEAT TREATMENT & FINAL FINISH



HANDLE - A153055



**ASSEMBLY OF
ALTERNATIVE DESIGN SHOWN
ON COMPONENT DRAWINGS
A153055 AND B147713**

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL.2	
RED.	
BR.	
ROCK.	

[illegible][illegible]

51-116	45 S.M.G-M1
51-124	45 S.M.G-M1A1
51-63	45 S.M.G-M28A1

LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	B147719	PIVOT, ROCKER, ASSEMBLY	
2		COMPOSED OF:-	
3	B147713	1-BODY, ROCKER PIVOT	*
4	A153055	1-HANDLE	*
5			

PIVOT, ROCKER, ASSEMBLY

6147719

~~©B-147719-3~~

* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES

A horizontal scale bar with markings for 0, 1, and 2 inches. The bar is divided into segments, with the first segment being smaller than the others. The markings are labeled '0', '1', and '2 INCHES'.

REF. DRG. A.Q.C.N-42-30
SPRINGFIELD ARMORY

~~B147719~~

OFFTSMAN J.P.	TRACER J.P.	L'DG. OFFTSMAN C.F.H.
CHECKER C.H.	<div style="text-align: center;"> </div>	CHIEF OFFTSMAN J.P.
SUBMITTED.		
<div style="text-align: center;"> </div>		
COL. ORD. DEPT..		

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:-

Schwabach
COL., ORD. DEPT., U. S. A.

ORDNANCE DEPT., U.S.A.

SUPERSEDES 9147710

HEAT TREATMENT & FINAL FINISH

PHYSICAL
PROPERTIES

Y.P.

T.S.

EL2

RED.

BR.

ROCK.

APRIL 30, 1942

REVISIONS

1	3-3-43
2	8-30-43
3	12-30-43
4	CONVERSION 10-30-51

DRG. PERTAINS TO

51-116	45 S.M.G.-MI
51-124	45 S.M.G.-MIAI
51-63	45 S.M.G.-M28AI

BODY-B147714

HANDLE-A153055

ASSEMBLY OF
ALTERNATIVE DESIGN
SHOWN ON COMPONENT
DRAWINGS
B147714 AND A153055

LIST OF COMPONENTS

1 LINE NUMBER	2 DRAWING NUMBER OR PIECE MARK	3 NAME OF COMPONENT	4 NO. REQUIRED PER UNIT ASM.
1	B147720	SAFETY, ASSEMBLY	(1)
2		COMPOSED OF:	
3	B147714	1-BODY, SAFETY	*
4	A153055	1-HANDLE	*
5			

SAFETY, ASSEMBLY ~~B147720~~ 3
6147720

DFTSMAN <i>Quill</i>	TRACER <i>Quill</i>	L'DG. DFTSMAN <i>G. J. T.</i>
CHECKER <i>E. G. W.</i>	CORR. DFTSMAN <i>E. G. W.</i>	S.A. <i>E. G. W.</i>

SUBMITTED:

Walter Sinton
COL., ORD. DEPT.
APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:
John A. Burch
COL., ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

B6147720

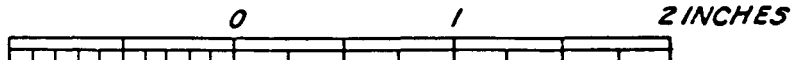
REF. DRG. A.O.C. A42-31
SPRINGFIELD ARMOY

~~B147720~~

B6147720

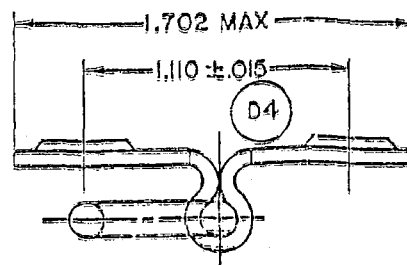
* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

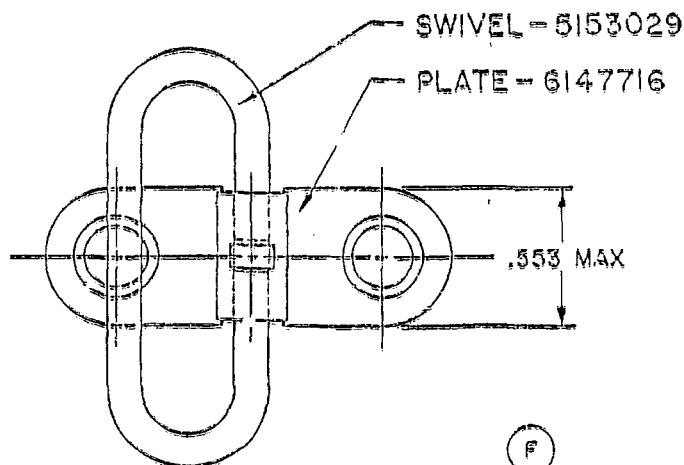


SUPERSEDES B147720

86147721



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B		5-21-92	
A	REDRAWN AND REVISED. SEE EO 3A 24438	5 JAN 98	
B	SEE EO NO. SA25099	JUN 99	
C	SEE EO NO. SA-25395	3 OCT 98	
D	(1-4) SEE EO NO. SA27712	3 OCT 98	
E	(1-3) SEE EO-88086	5 FEB 98	
F	(3) SEE ERR HQR 30602	8 JAN 73	
G	SEE ERR HQR 30644	8 MAR 73	
H	ERR Z9Z1169B (ECP W9S2019/790629)	891016	



NOTES:

1. EXCEPT AS SPECIFIED OTHERWISE
COMPONENT DRAWING DIMENSIONS
SHALL APPLY TO THIS ASSEMBLY
2. SWIVEL SHALL BE CAPABLE OF BEING
ROTATED 180° WITH THE FINGERS. .03
LATERAL MOVEMENT IS PERMISSIBLE.
3. MIL-W-13855 APPLIES.

CURRENT DESIGN ACTIVITY PAGE CODE 19300
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07804-5000

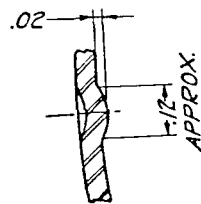
SEE PL-6147721.

PART NO. 6147721

E3	C	C11686409	SHOTGUN, 12GA	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	30 APR 42	SPRINGFIELD ARMORY SPRINGFIELD, MA 01101
			RIOT TYPE	YF	DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	DRAFTSMAN R.E.K.	CHECKER	
F	B	C7791354	LAUNCHER,	TS		TRACER R.E.K.	CHECKER C.R.C.	SWIVEL, SLING, ASSEMBLY
		D1101Q343	M79	EL2	MATERIAL	ENGR R.E.A.	ENGR N.W.G.	
DI	DI			RA	HEAT TREATMENT	SUBMITTED		CODE IDENT NO. 19205
				BIH		N.W. GRANT ORD CORR		
			NEXT ASSY USED ON	RIH	FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		B
			APPLICATION			H.F. LYNCH ORD CORR		
			DO NOT APPLY PART NO. --AS SPECIFIED--			SCALE 2/1 UNIT WT		SHEET 1 OF 1

SCANNED DUPLICATE ORIGINAL

HEAT TREATMENT & FINAL FINISH	



SECTION A-A
SCALE $\frac{4}{1}$

Y.P.	
T.S.	
EL.2	
RED.	
BR.	
ROCK.	

REVISIONS

DRG. PERTAINS TO

2

SUBMITTED: *Walter Benton*
COL. ORD. DEPT.: *Eck*

John A. Smith
COL. ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SPRINGFIELD ARMORY

B147757

SUPERSEDES B147757

86147757

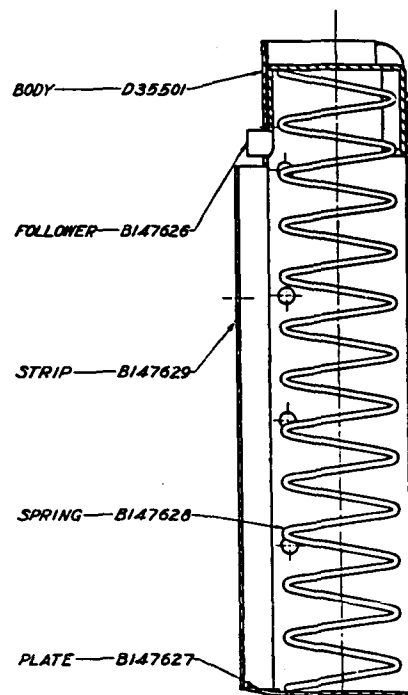
BRACKET, BUTT PLATE (B) 47757 +
FINISH
MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

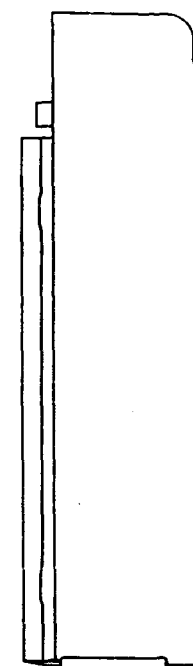
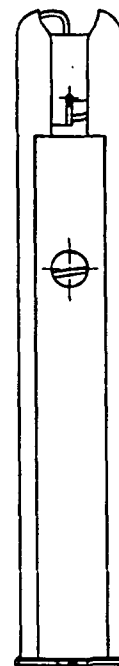
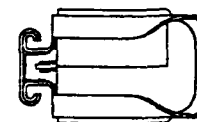
B6147757

SCALE $\frac{2}{1}$

LINE NUMBER	LIST OF DRAWINGS	DRAWING NUMBER	REVISION
1	MAGAZINE, BOX, 20 CARTRIDGE	D35500	✓
2	LIST OF PARTS	B147630	✓
3	LIST OF AUTHORIZED ASSEMBLIES	B147631	✓
4		B147626	✓
5		B147627	✓
6		B147628	✓
7		B147629	✓
8		C64340	✓
9		D35601	✓
10			
11			
LINE NUMBER	LIST OF SPECIFICATIONS	SPECIFICATION NUMBER	REVISION
1			
2	GENERAL SPECIFICATION GOVERNING THE		
3	MANUFACTURE AND INSPECTION OF SMALL ARMS		
4	WEAPONS AND ACCESSORIES	W34444-1	
5	METALS, GENERAL SPECIFICATION FOR INSPECTION OF	FE800-4-181	
6			
7	STEEL, CARBON AND ALLOY, SHEETS AND STRIPS	U3457-36	
8			
9	STANDARD SPECIFICATION FOR MARKING		
10	SHIPMENTS BY CONTRACTORS	USA 100-2	
11	WIRE, STEEL, SPRING, FOR SMALL ARMS WEAPONS	USA 40-7-1	
12	FINISHES, PROTECTIVE, FOR IRON AND STEEL PARTS	USA ST-0-2	
13			
14			
15			
16			
17			



CROSS SECTION



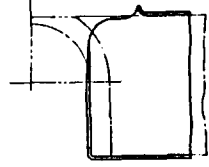
MAGAZINE, BOX, 20 CARTRIDGE			
LIST OF DRAWINGS AND SPECIFICATIONS			
SHOWING REVISIONS IN EFFECT ON			
REVISIONS		CLASS	DIVISION (DRAWING) FILE
1	1-2-42		
2	3-22-42		
3	3-26-42		
4	10-8-42		
5	5-3-43		
6	10-12-43		
7	11-10-46		
8	12-5-50		
DRG. PERTAINS TO		LTCOL. ORG. DEPT. USA	
D634834G-MRBAI		EXAMINED.	
D7115 435MG-MT		CAPT. ORG. DEPT. USA	
D1124 435MG-MT		APPROVED BY ORDER OF THE	
		CHIEF OF DIVISION	
		MAJOR. ORG. DEPT. USA	
		ORDNANCE OFFICE, WAR DEPT.	

D635500 D35500

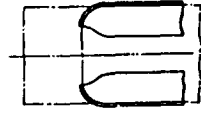
SUPERSEDES D35500

PHYSICAL PROPERTIES	Y.P.	
	T.S.	
	EL-2	
	RED	
	HTY	
	DR	
SCL		
	CC	

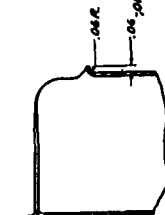
**MUST BE SMOOTH HERE AND
BREAT SHARP CORNERS —**



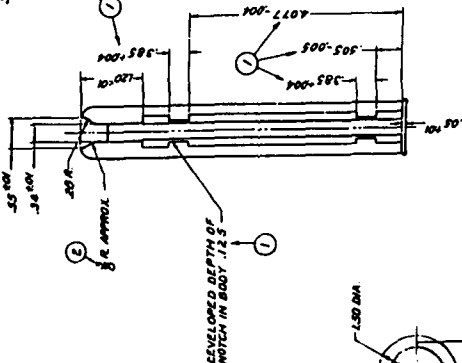
SECTION A-A WITH FORMING TOOL



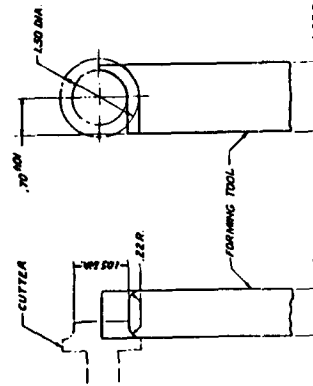
SECTION A-A WITH EXISTING TRAIL



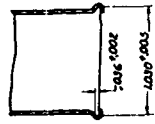
SCALE 1/2
SECTION B-B



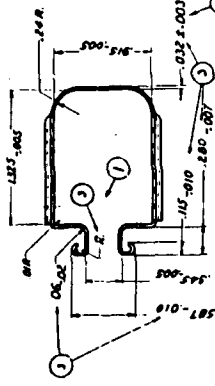
DEVELOPED DEPTH OF
NOTCH IN BODY .125 -



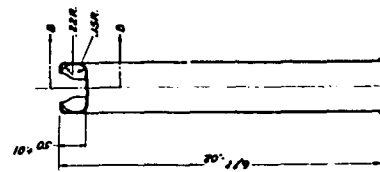
METHOD USED TO SHAPE FORMING TOOL



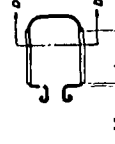
SECTION D-D
SCALE 3"



scale 1/2



4 TANGENT RADIUS



6535501
BODY, MAGAZINE
STEEL NO. 1023
MANUFACTURING COMPONENT
FINISH

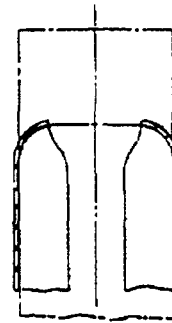
REF: J A 15085	<table border="1"> <tr> <td> <p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p> </td> <td> <p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p> </td> </tr> <tr> <td> <p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p> </td> <td> <p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p> </td> </tr> </table>	<p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p>	<p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>	<p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p>	<p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>
<p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p>	<p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>				
<p>REVISIONS</p> <p>11/15/54</p> <p>2/1/55</p> <p>2/1/55</p> <p>3/1/55</p> <p>4/1/55</p> <p>5/1/55</p> <p>6/1/55</p>	<p>CLASS</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>				
<p>CLASS PERTAINS TO</p> <p>ORIGIN NEGATIVE FOR</p> <p>TO CONTINUE</p> <p>EXPLANATION, HANDLING</p> <p>REMARKS</p>	<p>REASON</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>				
<p>CLASS PERTAINS TO</p> <p>ORIGIN NEGATIVE FOR</p> <p>TO CONTINUE</p> <p>EXPLANATION, HANDLING</p> <p>REMARKS</p>	<p>REASON</p> <p>INITIAL</p> <p>DATE</p> <p>BY</p> <p>REASON</p>				

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

06535501
scale f

SUPERSEDES D35501

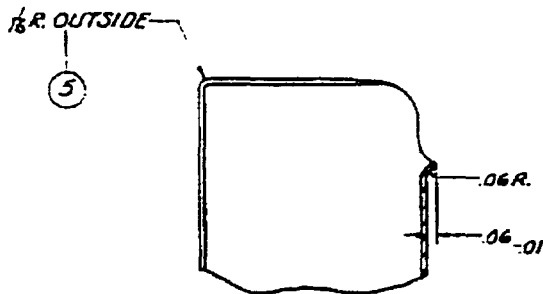
HEAT TREATMENT & FINAL FINISH



SECTION A-A WITH FORMING TOOL

SECTIONAL VIEWS SHOWING METI
FORMING TOOL TO SHAPE MOUTH

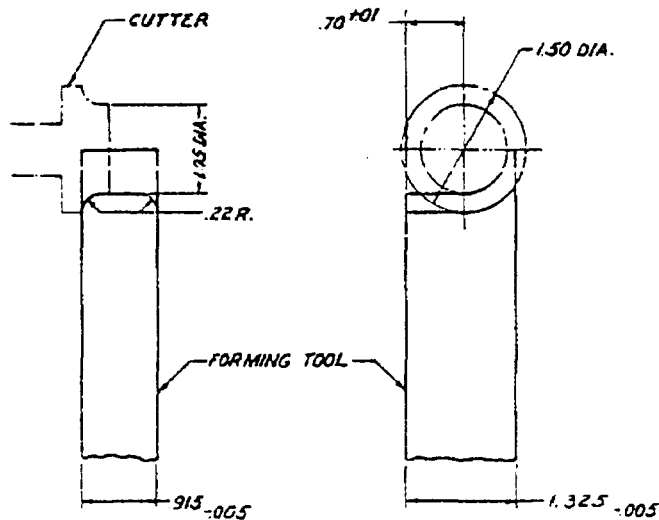
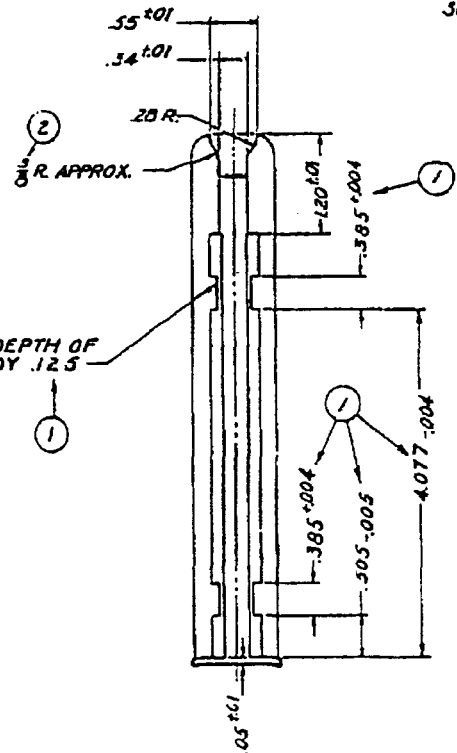
SCALE $\frac{2}{1}$



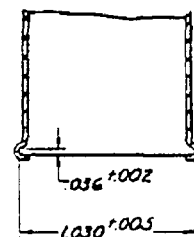
SECTION B-B

SCALE $\frac{2}{1}$

DEVELOPED DEPTH OF
NOTCH IN BODY .125



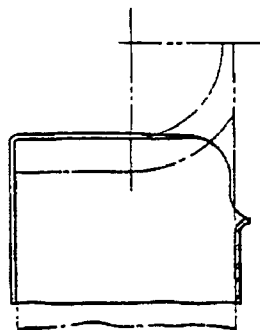
METHOD USED TO SHAPE
FORMING TOOL



SECTION D-D

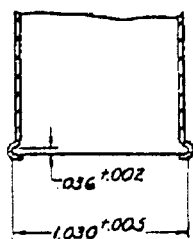
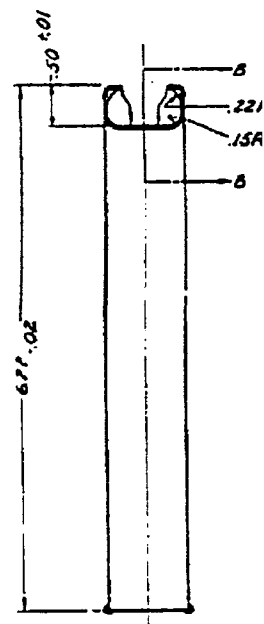
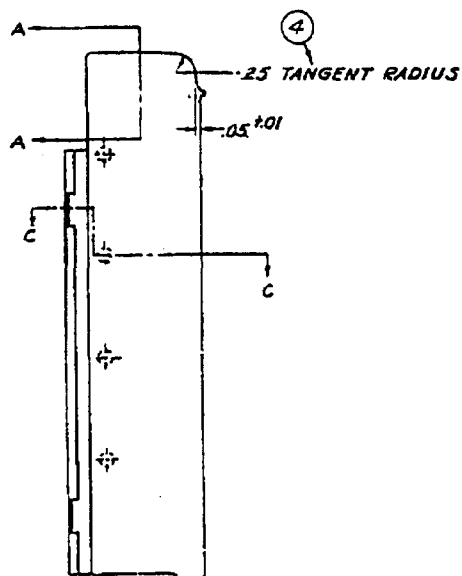
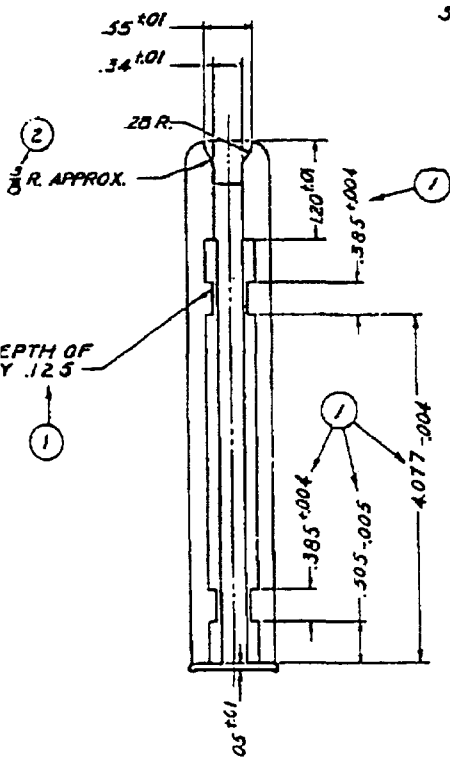
SCALE $\frac{2}{1}$

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.

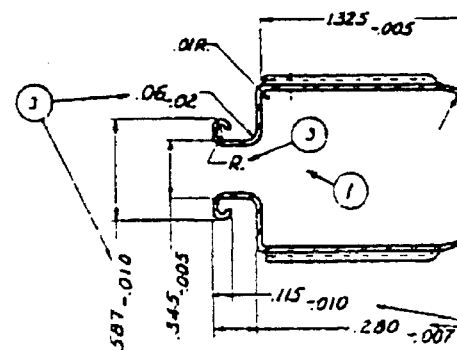
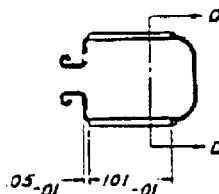


SECTION B-B WITH FORMING TOOL

SCALE $\frac{2}{1}$



SECTION D-D
SCALE $\frac{2}{1}$



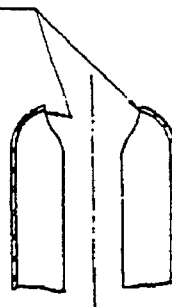
SECTION C-C
SCALE 2

6535501
BODY, MAGAZINE ~~6535501~~ 1 5
STEEL-WD 1025
FINISH F
MANUFACTURING COMPONENT
1 2

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL-2	
RED.	
HT.T.	
BR.	
SCL.	
C.C.	

D6535501

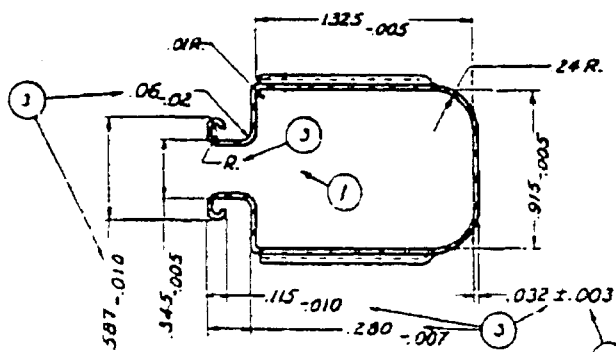
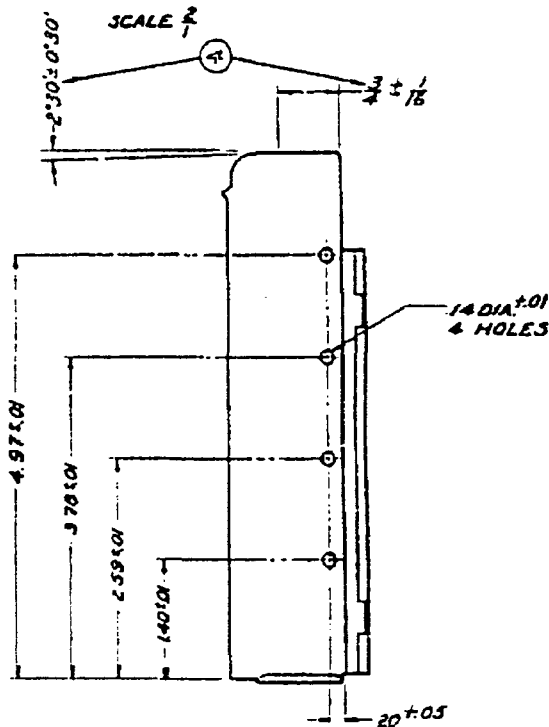
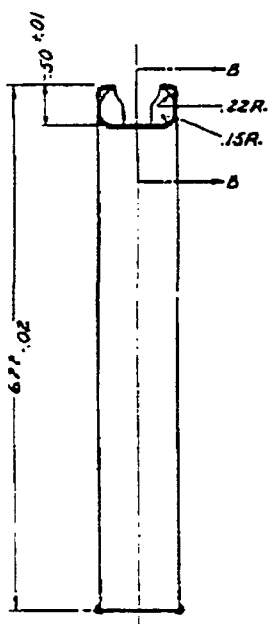
MUST BE SMOOTH HERE AND
BREAK SHARP CORNERS



SECTION A-A

SCALE $\frac{1}{2}$

4
5 TANGENT RADIUS



SECTION C-C

SCALE $\frac{1}{2}$

REF. J.A.15305

AUGUST 28, 1941		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	1-2-42				
2	2-11-42				
3	11-15-42				
4	5-18-43				
5	8-9-43				
6	10-20-51				
		OFFSMAN	TRACER	LTJG. OFFSMAN	
		ADJ	W.M.S.	614	
		CHECKER	W.A.	CHIEF OFFSMAN	
		C.H.	60	W.B.A.	56
		SUBMITTED:			
		J.H. W.C. S.			
		ORG. PERTAINS TO			
		LT. COL. ORD. DEPT. U.S.A.			
		EXAMINED:			
		W.C. S.			
		CAPT. ORD. DEPT. U.S.A.			
		APPROVED BY ORDER OF THE			
		CHIEF OF ORDNANCE:			
		W.C. S.			
		MAJOR ORD. DEPT. U.S.A.			
		ORDNANCE OFFICE, WAR DEPT.			

D6535501 SCALE $\frac{1}{2}$

SUPERSEDES 035501

NOTE:-
DIMENSIONS FOR SLOT ARE
AFTER COMPLETE ASSEMBLY

NOTE:-
SURFACE MUST BE .04 TO .06 INCH
CONVEX CURVATURE AT THE HUB HOLE

200 F.125 DIA+.003 4 HOLES

125 DIA $\pm .003$ 2 HOLES-
THESE HOLES MUST LINE UP WITH HOLES
IN C-64350 MAGAZINE BODY SLIDE

-VERY SMOOTH CORNERS

ANGLES MEASURED
FROM RADIAL OF
EACH SLOT

2000

DETAIL VIEW OF SLOT
SCALE $\frac{5}{7}$

BODY, MAGAZINE 6535502
STEEL WD 1020 ② 35502
FINISH
MANUFACTURING COMPONENT

THESE DIMENSIONS ARE DIE DIMENSIONS
FOR JIG BORING OPERATION

REF. DRG. UNITED AIR CLEANER CO. 50025

1	OCTOBER 20, 1941	CLASS	DIVISION	BRANCHING	FILE
2	REVIEWS				
3	1 OF 12				
4					
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TOLERANCE : ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SCALE +
D6535502

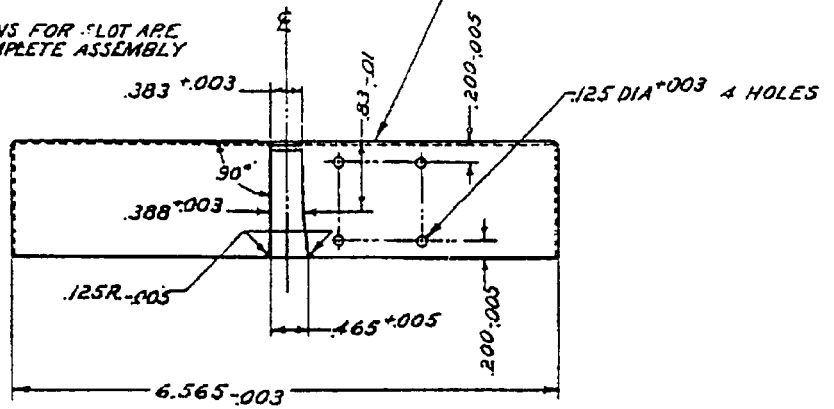
SUPERSEDES 035502

06535502

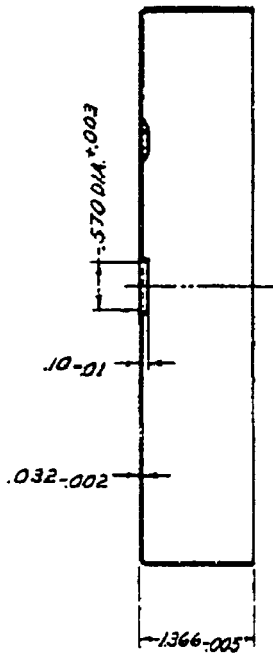
HEAT TREATMENT & FINAL FINISH

NOTE:-
DIMENSIONS FOR SLOT ARE
AFTER COMPLETE ASSEMBLY

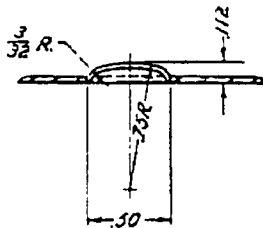
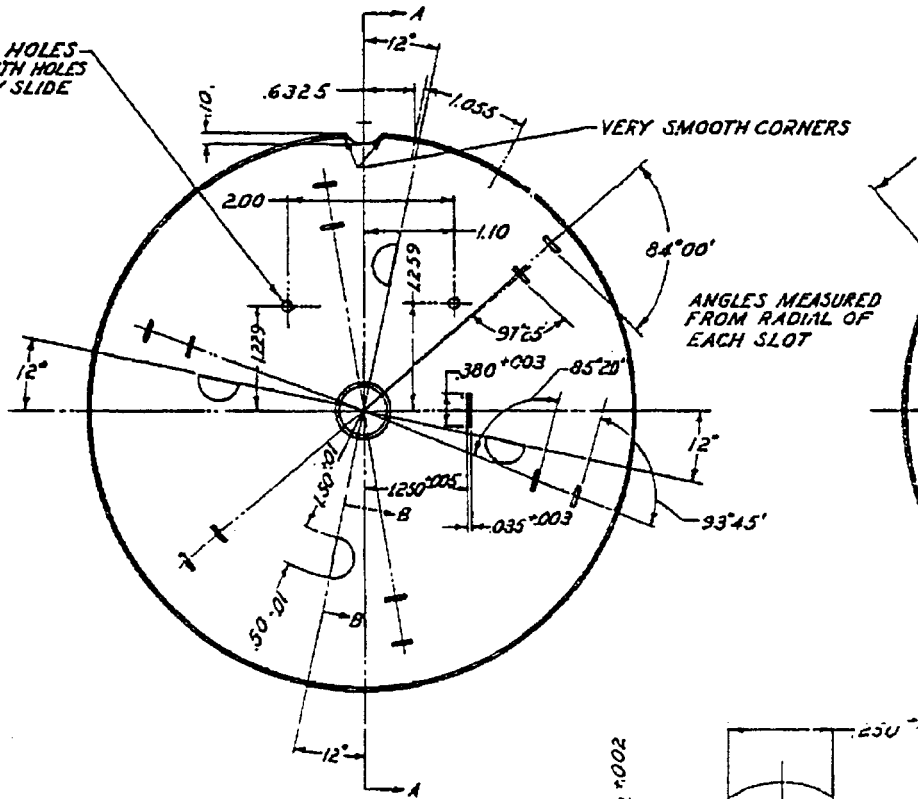
NOTE:-
— SURFACE MUST BE .04 TO .06 I.
CONVEX CURVATURE AT THE H



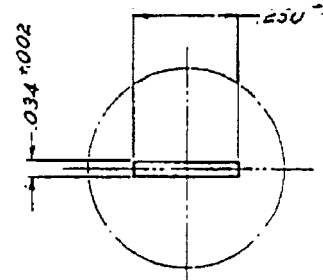
*.125 DIA. +.003 2 HOLES-
THESE HOLES MUST LINE UP WITH HOLES
IN C64356 MAGAZINE BODY SLIDE*



SECTION A-A



SECTION BB
SCALE $\frac{2}{1}$



DETAIL VIEW OF SLOT
SCALE $\frac{5}{1}$

TOLERANCE \pm ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

Technical drawing of a mechanical part with dimensions and tolerances:

- Top horizontal dimension: $8.3 \pm .01$
- Top vertical dimension: $.200 \pm .005$
- Bottom horizontal dimension: $.165 \pm .005$
- Bottom vertical dimension: $.200 \pm .005$
- Feature callout: $.125 \text{ DIA} \pm .003 \text{ 4 HOLES}$

Technical drawing of a circular part with slots and dimensions. The drawing includes the following features and dimensions:

- Dimensions:**
 - 1.055 (horizontal distance from center to slot edge)
 - 1.10 (horizontal distance from center to slot edge)
 - 1.259 (vertical distance from center to slot edge)
 - 380 ± 0.003 (width of the slot)
 - 0.35 ± 0.003 (width of the slot)
 - 0.35 ± 0.003 (width of the slot)
 - 12° (angle of the slot)
 - 33°45' (angle of the slot)
 - 85°20' (angle of the slot)
 - 97°25' (angle of the slot)
 - 84°00' (angle of the slot)
- Annotations:**
 - VERY SMOOTH CORNERS
 - ANGLES MEASURED FROM RADIAL OF EACH SLOT

Figure 1 is a circular diagram showing the layout of a circular structure. The diagram includes various dimensions and angles. A central circle is surrounded by a larger circle. Radial lines extend from the center to the outer circle. Dimensions are given for the radii of the central and outer circles, and for the distances between the radial lines. Angles are given for the sectors between the radial lines. The diagram is labeled 'Figure 1' and 'Figure 2'.

Technical drawing of a mechanical part showing a cross-section. The drawing includes dimensions: 250, 200, and 0.34 ± 0.002.

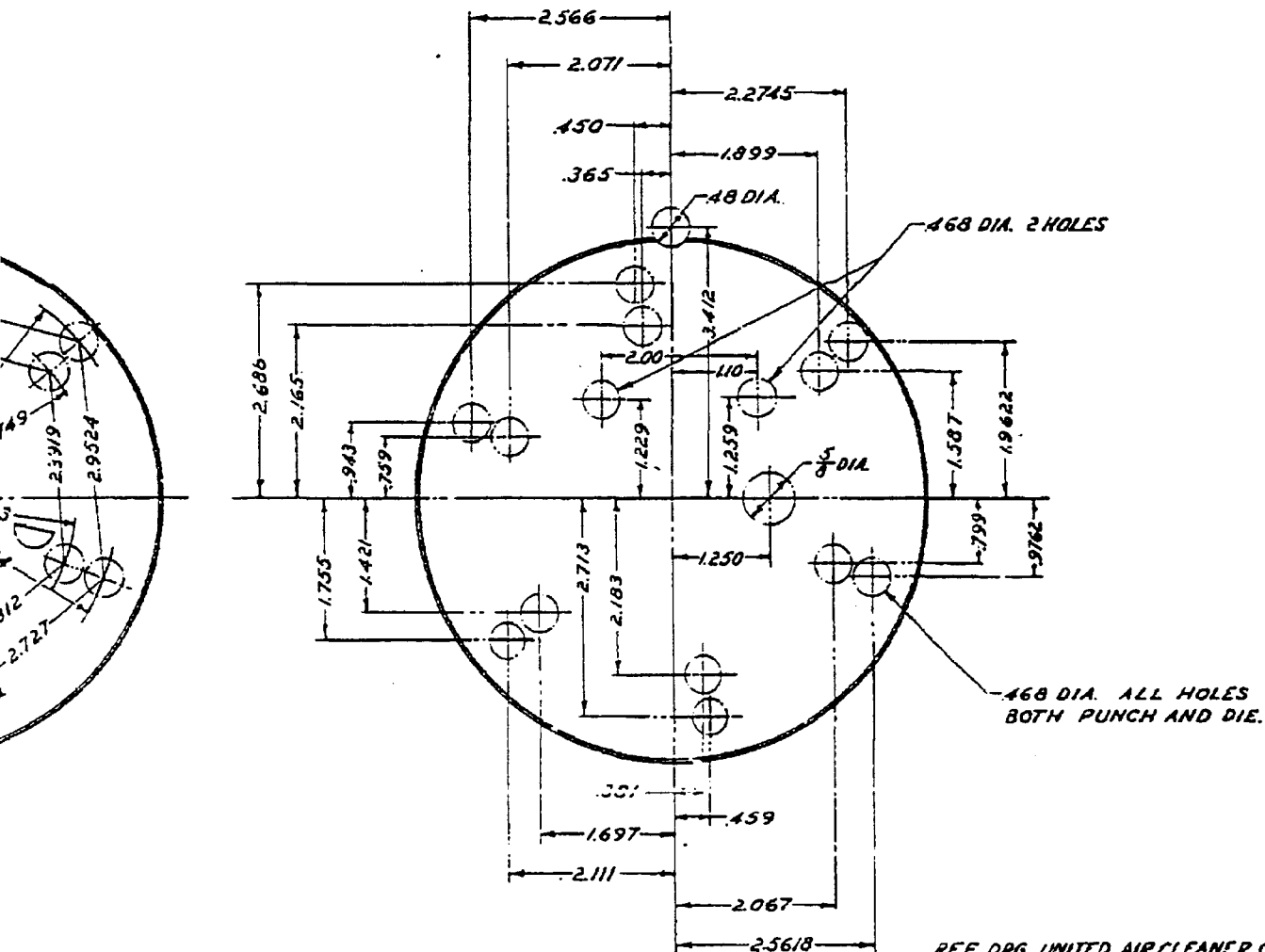
DETAIL VIEW OF SLOT
SCALE $\frac{5}{1}$

6535502
BODY, MAGAZINE (D) 35502-
STEEL WD 1020
 FINISH
 MANUFACTURING COMPONENT

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL 2	
RED.	
BR.	
ROCK	B 63-64
SCL	

06535502

THESE DIMENSIONS ARE DIE DIMENSIONS
FOR JIG BORING OPERATION



REF. DRG. UNITED AIR CLEANER CO. 50025

6535502
DY, MAGAZINE 035502
STEEL WD 1020
FINISH
MANUFACTURING COMPONENT

OCTOBER 20, 1941	CLASS	DIVISION	DRAWING	FILE
REVISIONS				
1	10-25-41			
SYMBOL				
DRG. PERTAINS TO D35305 MAGAZINE, DRUM 50 CARTRIDGE 664350 BODY, MAGAZINE ASSEMBLY				
SUBMITTED: LT COL. GAB DEPT. U. S. A.				
EXAMINED: ORG DEPT. U. S. A.				
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: COL. GAB DEPT. U. S. A.				
ORDNANCE DEPT. U. S. A.				

SCALE +
06535502

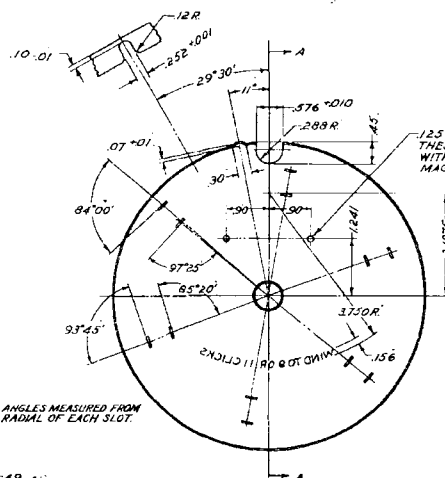
SUPERSEDES D35502

HEAT TREATMENT & FINAL FINISH

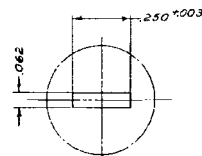
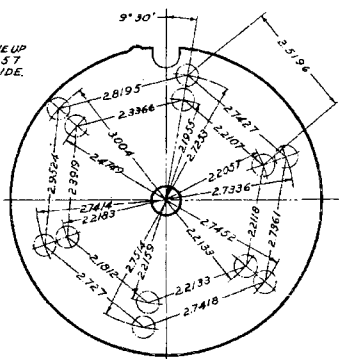
PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL. 2	
RED.	
BR.	
MCL	86465
ECI	

06535503

NOTE: SURFACE MUST BE .04 TO .06 INCH CONVEX CURVATURE AT THE HUB HOLE.

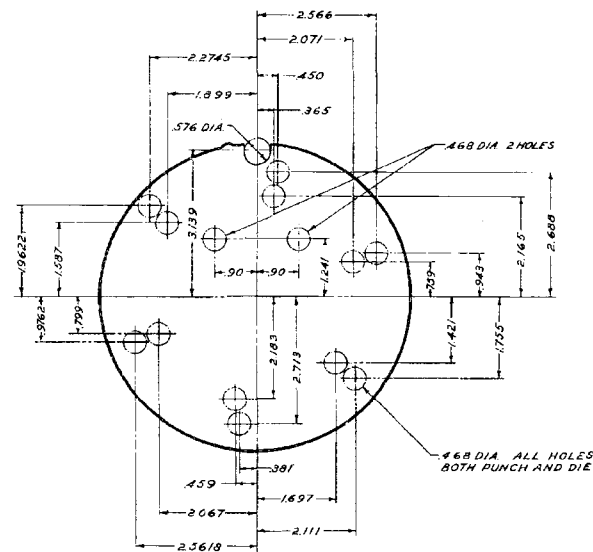


12.5 DIA ±.003 2 HOLES THESE HOLES MUST LINE UP WITH HOLES IN C64357 MAGAZINE COVER SLIDE.



DETAIL VIEW OF SLOT
SCALE 3/4

THESE DIMENSIONS ARE DIE DIMENSIONS FOR JIG BORING OPERATION



REF. DRG. UNITED AIR CLEANER CO. 50024

REVISIONS	CLASS	DIVISION	DRAWING	FILE
1				
SYMBOL				
DRG. PERTAINS TO				
D35503 MAGAZINE DRUM				
SPECIFICATION				
C64360 COVER MAGAZINE ASSEMBLY				
EXAMINED:				
APPROVED BY:				
ORDNANCE DEPT. U.S.A.				

COVER MAGAZINE 6535503
STEEL WD 1020
FINISH
MANUFACTURING COMPONENT

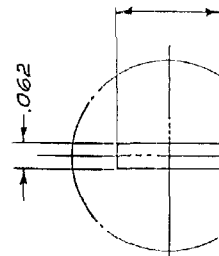
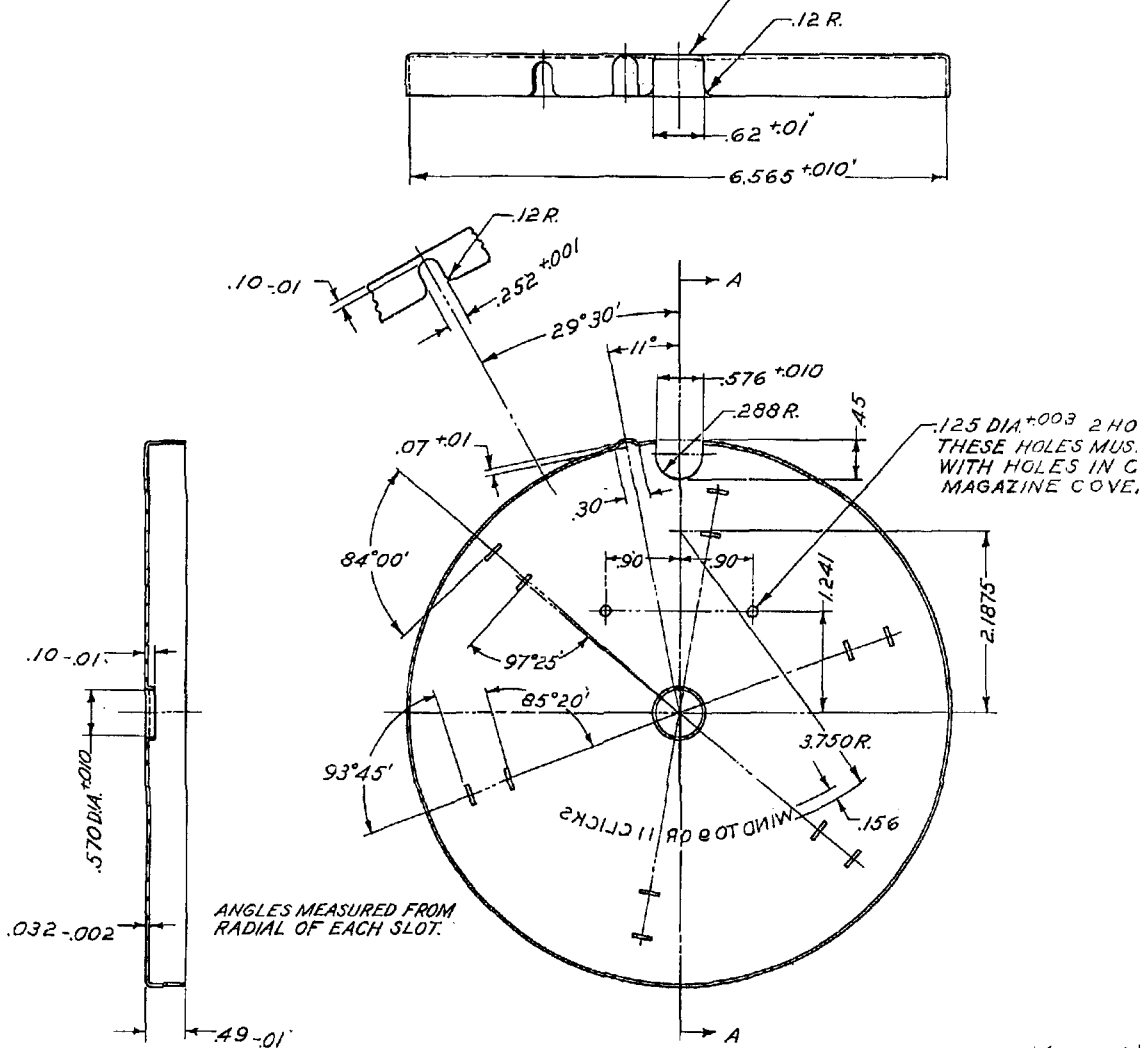
06535503
SCALE 1/4

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES D35503

HEAT TREATMENT & FINAL FINISH

NOTE:-
SURFACE MUST BE .04 TO .06
CONVEX CURVATURE AT THE F.



DETAIL VIEW C

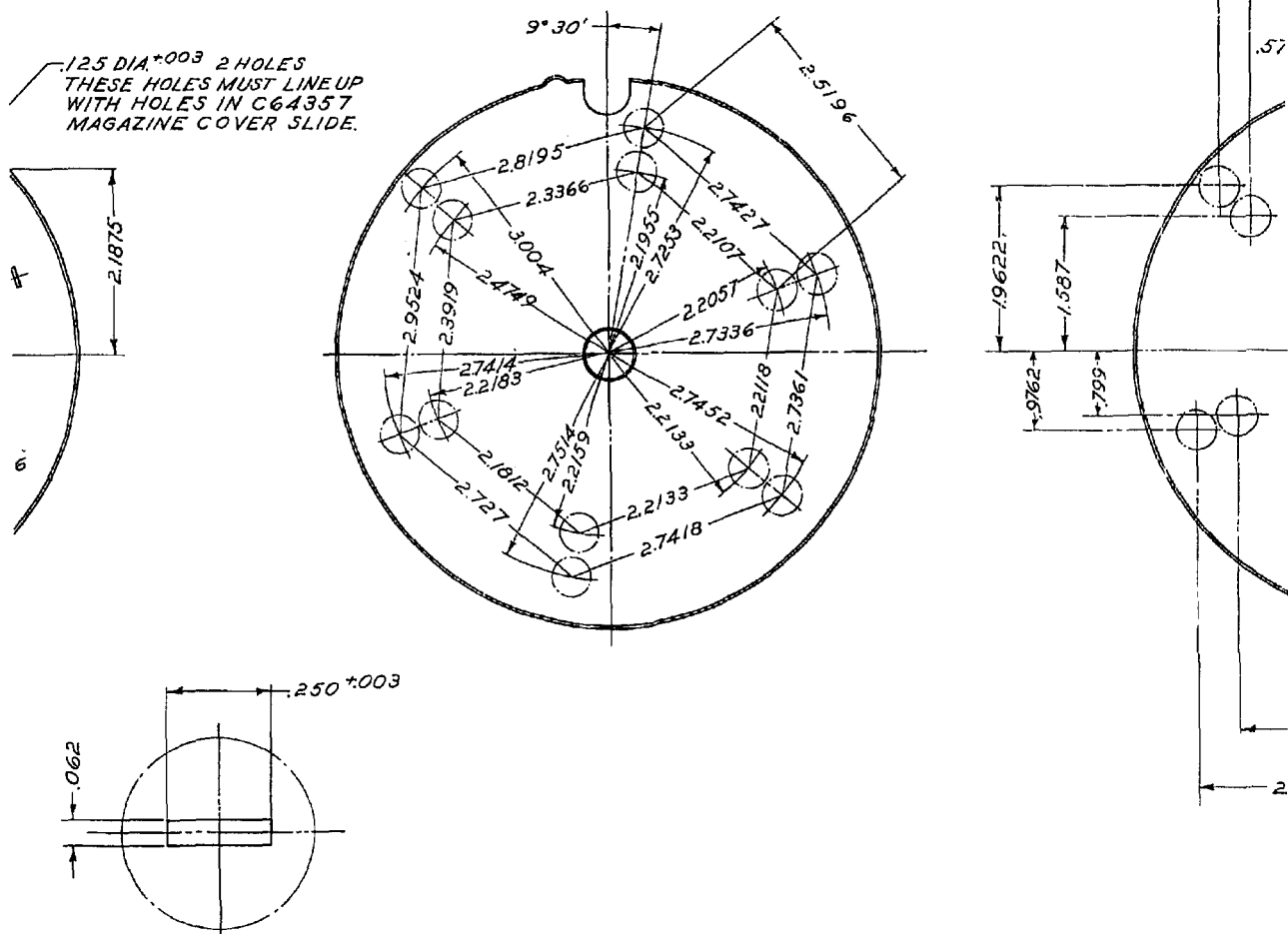
SCALE $\frac{5}{7}$

TOLERANCE ± ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

THE MUST BE .04 TO .06 INCH
X CURVATURE AT THE HUB HOLE.



THESE DIM.
FOR J1



DETAIL VIEW OF SLOT

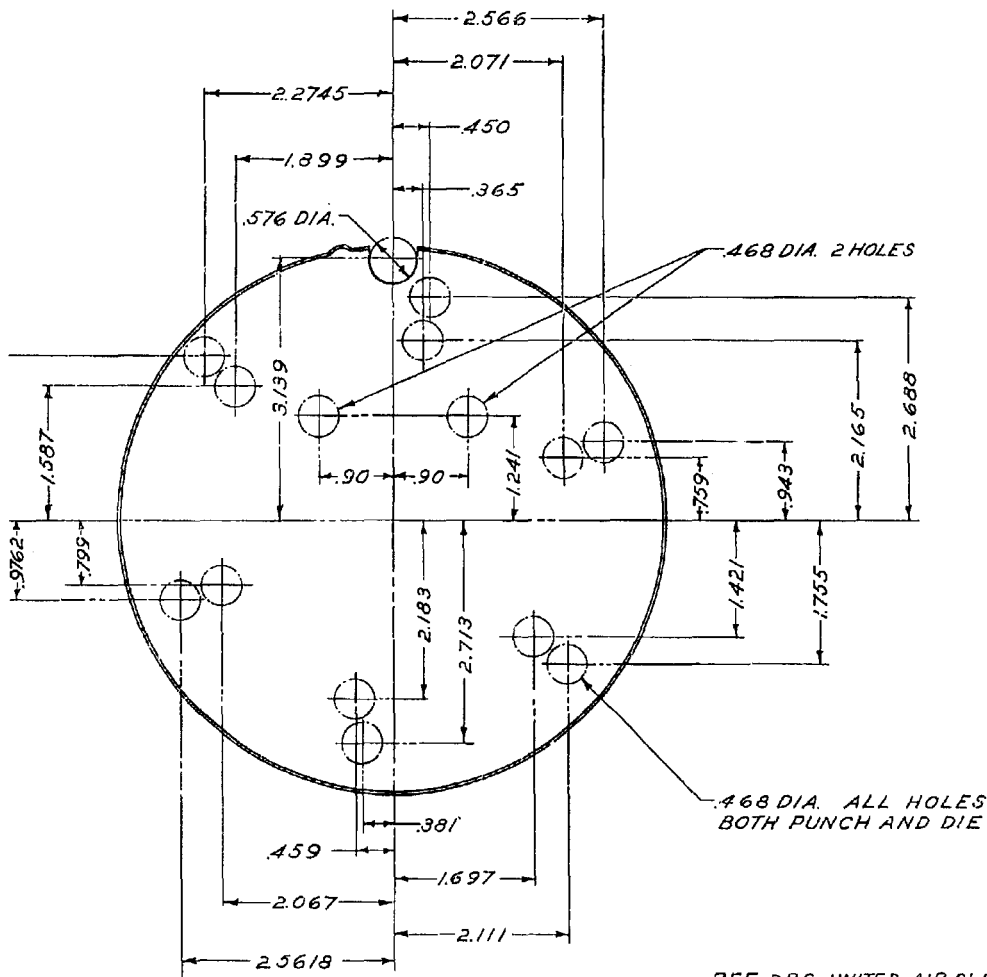
SCALE $\frac{5}{1}$

COVER, MAGAZINE 6535503
STEEL WD 1020
FINISH J¹
MANUFACTURING COMPONENT

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL.2	
RED.	
BR.	
ROCK	B 64-65
SCL.	

D6535503

THESE DIMENSIONS ARE DIE DIMENSIONS
FOR JIG BORING OPERATION.



REF. DRG. UNITED AIR CLEANER CO. 50024

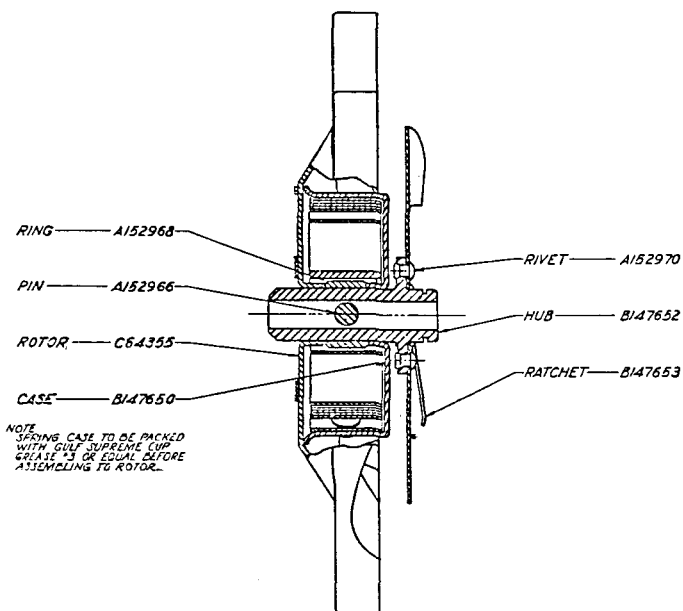
OCTOBER 20, 1941		CLASS	DIVISION	DRAWING	FILE									
REVISIONS														
1	10-30-51													
SYMBOL														
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DFTSMAN	TRACER	L'DG. DFTSMAN												
CHECKER		CHIEF DFTSMAN												
SUBMITTED														
DRG. PERTAINS TO														
D35503	MAGAZINE, DRUM													
C64360	COVER, MAGAZINE ASSEMBLY													
<table border="1"> <tr> <td colspan="3">L.T. COL., ORD. DEPT., U.S.A.</td> </tr> </table>						L.T. COL., ORD. DEPT., U.S.A.								
L.T. COL., ORD. DEPT., U.S.A.														
EXAMINED:														
ORD. DEPT., U.S.A.														
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:														
<table border="1"> <tr> <td colspan="3">L.T. COL., ORD. DEPT., U.S.A.</td> </tr> </table>						L.T. COL., ORD. DEPT., U.S.A.								
L.T. COL., ORD. DEPT., U.S.A.														
ORDNANCE DEPT., U.S.A.														

6535503
D35503

NT

D6535503
SCALE +

SUPPERSIDES D35503



PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL.2	
RED.	
HT.T	
BR.	
SCL.	
C.C.	

\$					
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6535504
ROTOR ASSEMBLY (6535504)

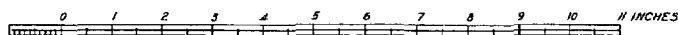
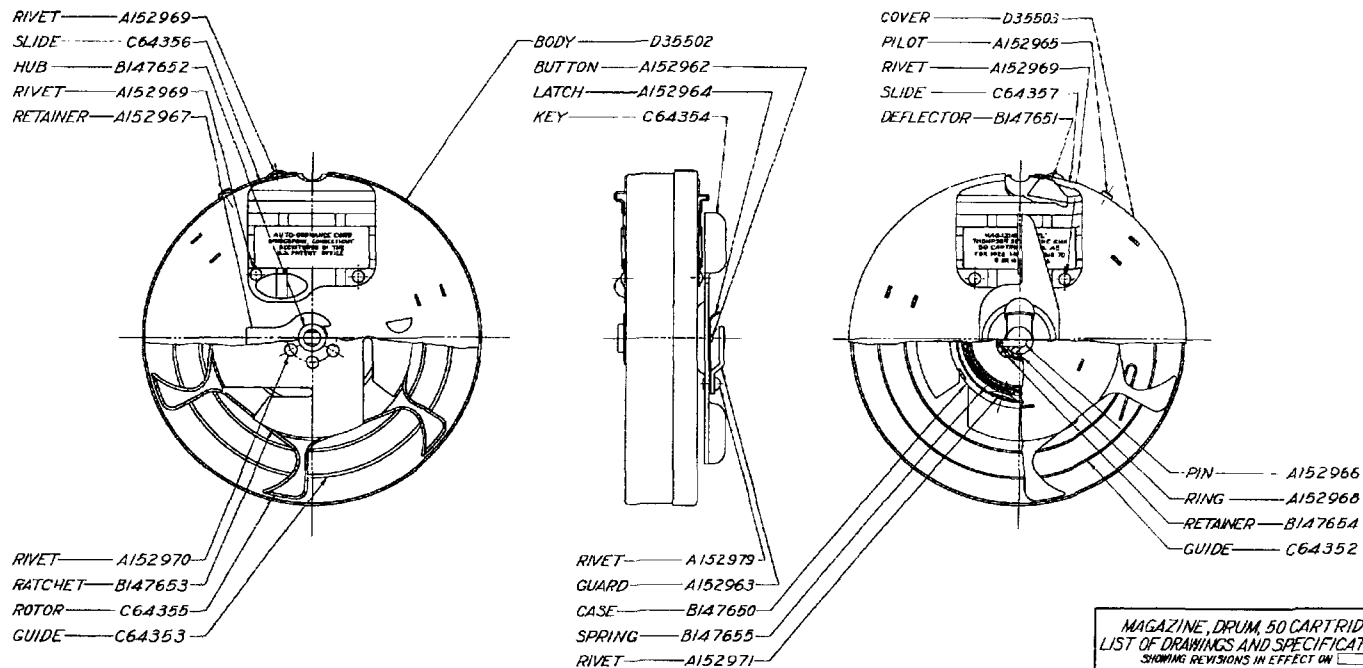
* WILL NOT BE ISSUED FOR FIELD MAINTENANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES



REF: UNITED AIR CLEANER CO. DRG 50032

OCTOBER 20, 1961		CLASS		DIVISION		DRAWING		FILE	
REVISONS									
1		REVISIONS		DATE		BY		REASON	
1		10/20/61							
SYMBOL									
OFFSHAW TRACER L/D OFFSHAW									
7 1/2 1/2 1/2 1/2 1/2 1/2 1/2 1/2 1/2									
ENGINEER R. J. HUFF OFFSHAW									
SUBMITTED: 10/20/61									
DRG. PERTAINS TO									
CLASS MAGAZINE DRUM									
30 CARTRIDGE									
EXAMINED:									
2ND DEPT. U.S.									
APPROVED BY DESIG. OF THE									
CHIEF OF ORDNANCE:									
9-2000									
COLOR DRG. U.S.									
ORDNANCE OFFICE, WAF DEPT.									
SUPERSEDES 035504									

LINE NUMBER	LIST OF DRAWINGS	DRAWING NUMBER	REVISION
1	MAGAZINE, DRUM, 50 CARTRIDGE	D35505	
2	LIST OF PARTS	B147648	
3	LIST OF PARTS	B147648A	
4	LIST OF AUTHORIZED ASSEMBLIES	B147649	
5	LIST OF AUTHORIZED ASSEMBLIES	B147649A	
6		A152962	
7		A152963	
8		A152964	
9		A152965	
10		A152966	
11		A152967	
12		A152968	
13		A152969	
14		A152970	
15		A152971	
16		B147650	
17		B147651	
18		B147652	
19		B147653	
20		B147654	
21		B147655	
22		B147656	
23		C64352	
24		C64353	
25		C64354	
26		C64355	
27		C64356	
28		C64357	
29		C64358	
30		C64359	
31		C64360	
32		C64361	
33		C64362	
34		C64363	
35		D35502	
36		D35503	
37		D35504	
38		A152979	
39			
40			
LINE NUMBER	LIST OF SPECIFICATIONS	SPECIFICATION NUMBER	REVISION
1	GENERAL SPECIFICATION GOVERNING THE		
2	MANUFACTURE AND INSPECTION OF SMALL ARMS		
3	WEAPONS, SPARE AND REPLACEMENT PARTS,		
4	AND ACCESSORIES	USA 7204	
5	METALS, GENERAL SPECIFICATION FOR INSPECTION OF	FED 90481	
6	STANDARD SPECIFICATION FOR MARKING SHIPMENTS	USA 1002	
7	BY CONTRACTORS		
8	STEEL, CARBON AND ALLOY SHEETS AND STRIPS	USA 67136	
9	STEEL, (SPRING) SPECIAL COLD-ROLLED STRIP	S15-160	
10	(ANNEALED)		
11	STEEL, CARTRIDGE-CLIP, STRIP WD 1045 SPECIAL		
12	ANNEALED	MIL-L-3093	
13	STEEL, ALLOY BARS (GENERAL PURPOSE)	FED 905424	
14	STEEL, CARBON BARS (GENERAL PURPOSE)	FED 905425	



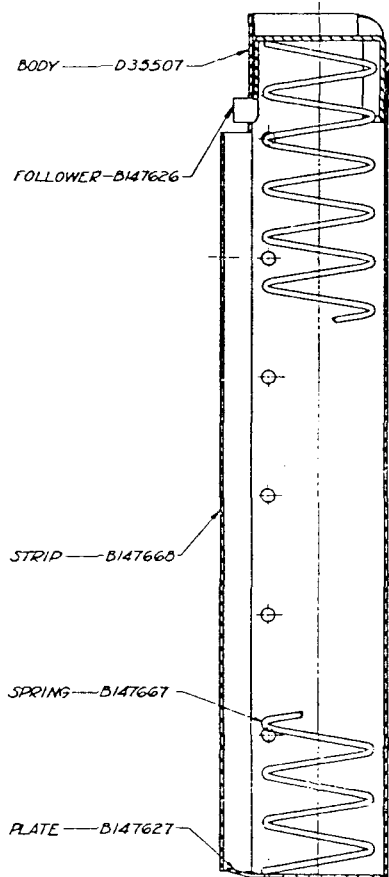
MAGAZINE, DRUM, 50 CARTRIDGE		CLASS	DIVISION	DRAWING	FILE
LIST OF DRAWINGS AND SPECIFICATIONS					
SHOWING REVISIONS IN EFFECT ON					
OCTOBER 20, 1941					
REVISIONS					
1	7-20-40				
2	10-28-40				
SYMBOL					
DO NOT INSCRIBE PART NO.					
OFFICER TRACER LT. COL. OFFICER					
A.D. A.D. C.M.					
CHECKER CHIEF OFFICER					
SUBMITTED BY					
LT. COL. ORD. DEPT. U.S.A.					
DRG. PERTAINS TO					
5-63 143246-1281					
EXAMINED					
ORD. DEPT. U.S.A.					
APPROVED BY ORDER OF THE					
CHIEF OF ORDNANCE					
COL. ORD. DEPT. U.S.A.					
ORDNANCE OFFICE, WAR DEPT.					

D6535505

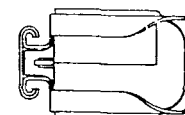
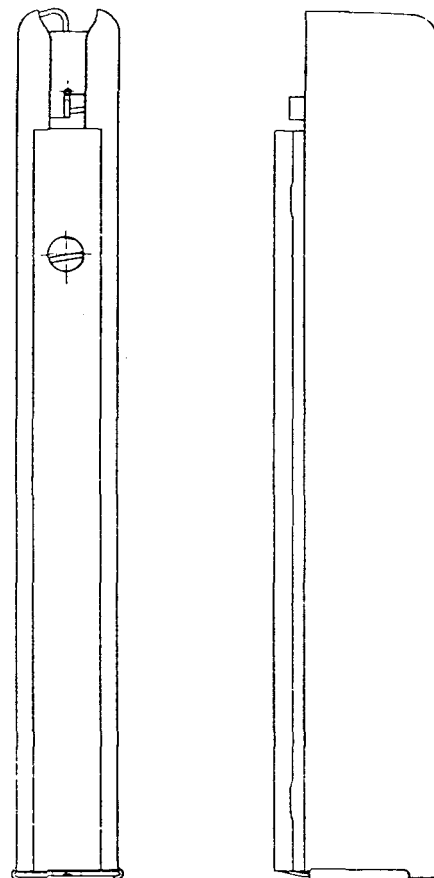
D35505

SUPERSEDES D35505

LINE NUMBER	LIST OF DRAWINGS	DRAWING NUMBER	REVISION
1	MAGAZINE, BOX, 30 CARTRIDGE	D35506	
2	LIST OF PARTS	B147665	
3	LIST OF AUTHORIZED ASSEMBLIES	B147666	
4		B147626	
5		B147627	
6		B147667	
7		B147660	
8		C64366	
9		D35507	
10			
11			
LINE NUMBER	LIST OF SPECIFICATIONS	SPECIFICATION NUMBER	REVISION
1			
2	GENERAL SPECIFICATION GOVERNING THE MANUFACTURE AND INSPECTION OF SMALL ARMS WEAPONS AND ACCESSORIES	USA 32-01	
3			
4	METALS, GENERAL SPECIFICATION FOR INSPECTION OF	FE 000-151	
5			
6			
7	STEEL, CARBON AND ALLOY, SHEETS AND STRIPS	USA 37-136	
8			
9			
10	STANDARD SPECIFICATION FOR MARKING		
11	SHIPMENTS BY CONTRACTORS	USA 100-2	
12	WIRE, STEEL, SPRING, FOR SMALL ARMS WEAPONS	USA 48-7-1	
13	FINISHES, PROTECTIVE, FOR IRON AND STEEL PARTS	USA 37-0-2	
14			
15			
16			
17			



CROSS SECTION



TOP VIEW

MAGAZINE, BOX, 30 CARTRIDGE			
LIST OF DRAWINGS AND SPECIFICATIONS			
SHOWING REVISIONS IN EFFECT ON			
DEC. 20, 1941		CLASS / DIVISION / DRAWING FILE	
REVISIONS			
1	13-01-42		
2	13-01-42		
3	10-01-42		
4	9-01-42		
5	10-01-42		
6	11-01-42		
7	12-01-42		
DRG. PERTAINS TO		LTCOL ORG DEPT USA	
57-03 45506-M20A1		EXAMINED	
57-03 45506-M20A1		CAPT ORG DEPT USA	
57-03 45506-M20A1		APPROVED BY ORDER OF THE	
57-03 45506-M20A1		CHIEF OF ORDNANCE	
57-03 45506-M20A1		CAPT ORG DEPT USA	
57-03 45506-M20A1		ORDNANCE OFFICE, WAR DEPT.	

D6535506

D35506

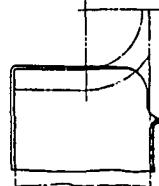
SUPERSEDES D35506

D6535506

HEAT TREATMENT & FINAL FINISH



SECTION A-A WITH FORMING TOOL

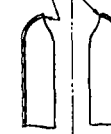


SECTION B-B WITH FORMING TOOL

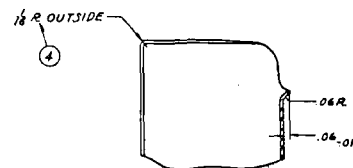
SECTIONAL VIEWS SHOWING METHOD OF USING FORMING TOOL TO SHAPE MOUTH OF MAGAZINE BODY

SCALE $\frac{1}{8}$

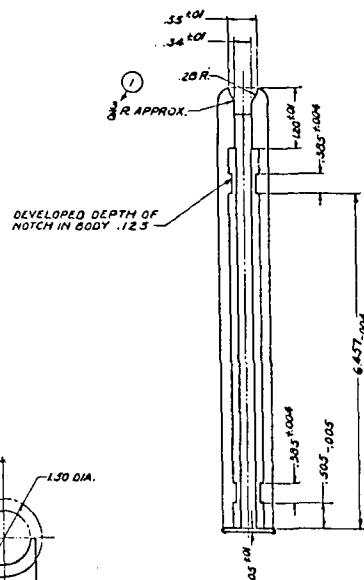
MUST BE SMOOTH HERE AND BREAK SHARP CORNERS



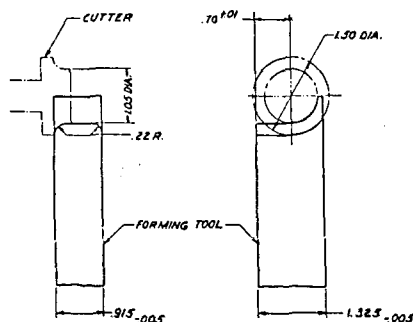
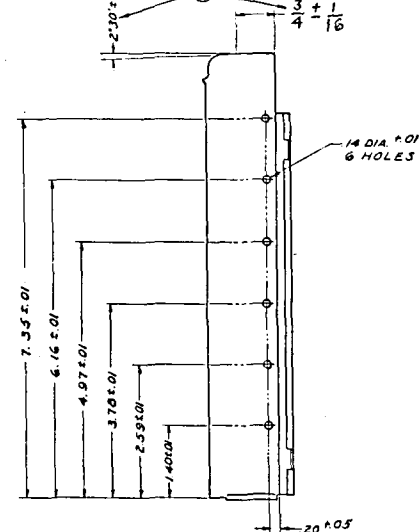
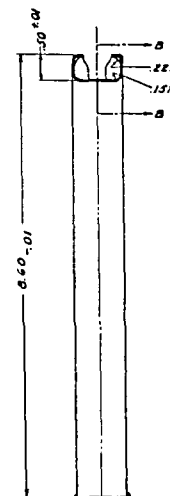
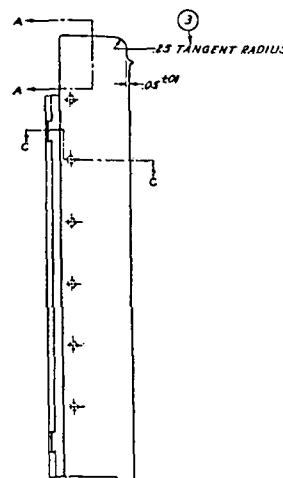
SECTION A-A
SCALE $\frac{1}{8}$



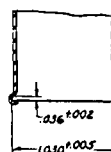
SECTION B-B
SCALE $\frac{1}{8}$



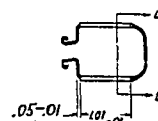
DEVELOPED DEPTH OF NOTCH IN BODY .125



METHOD USED TO SHAPE FORMING TOOL

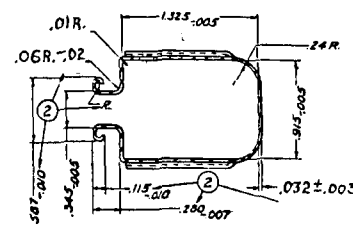


SECTION D-D
SCALE $\frac{1}{8}$



BODY, MAGAZINE
STEEL - W.D. 1025
FINISH F
MANUFACTURING COMPONENT

6535507 (3) (4)
6535507 (1) (2)



SECTION C-C
SCALE $\frac{1}{8}$

REF. ORG. 3A.15305

DEC. 20, 1941	CLASS	DIVISION	DRAWING	FILE
REVISIONS				
14 2-11-42				
23 1-16-42				
37 5-18-43				
47 8-9-43				
5 1-21-44				
SYMBOL				
OFFMAN: TRACER L'DG OFFMAN				
CHECKER: L.D. L. CHIEF OPTSMAN				
SUBMITTED: mela				
EXAMINED: LT COL. ORD. DEPT. USA				
DRG. PERTAINS TO				
BLANCH MAGAZINE, BOX				
30 CARTRIDGE				
EAST TUBE MAGAZINE				
ASSEMBLY				
APPROVED BY ORDER OF THE				
CHIEF OF ORDNANCE				
JAN 10 1944				
ORDNANCE OFFICE, WAR DEPT.				

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

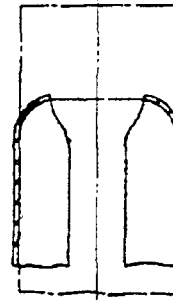
6535507

SCALE $\frac{1}{8}$

SUPERSEDES D35507

D6535507

HEAT TREATMENT & FINAL FINISH

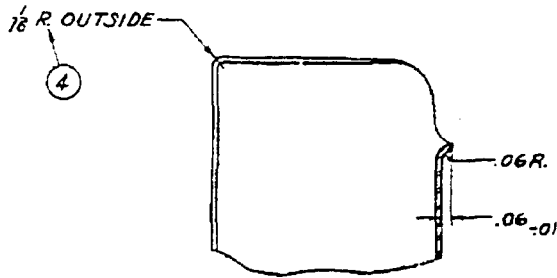


SECTION A-A WITH FORMING TOOL

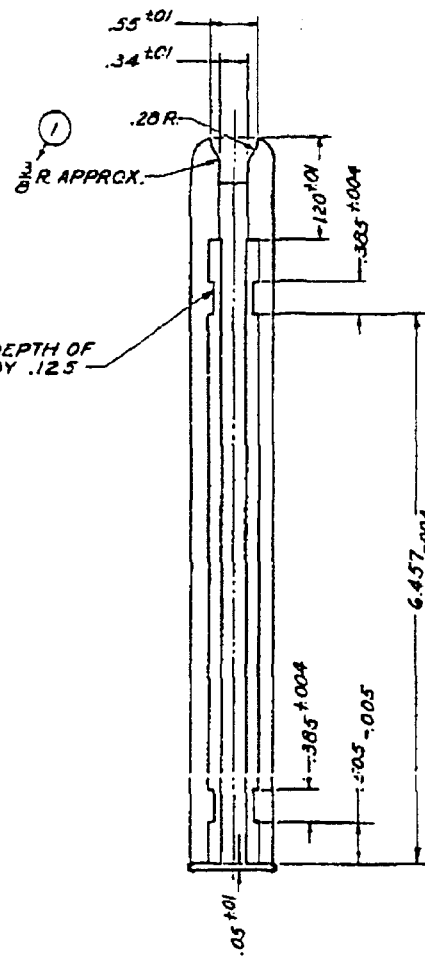


SECTION B-B

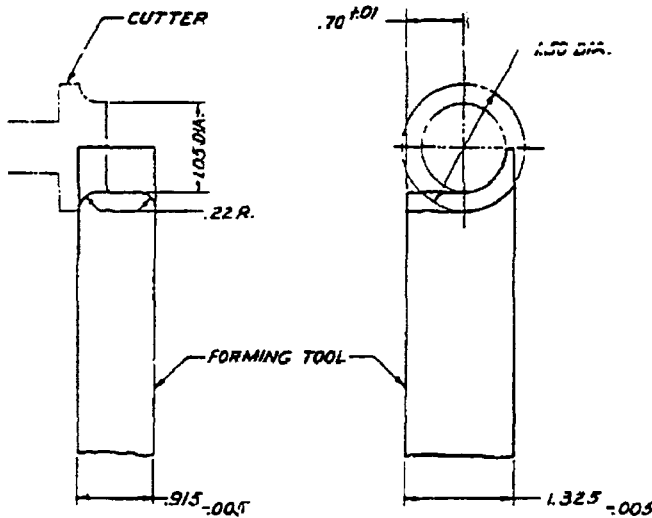
SECTIONAL VIEWS SHOWING METHOD OF USING FORMING TOOL TO SHAPE MOUTH OF MAGAZINE BODY



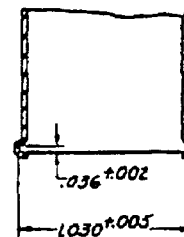
SECTION B-B
SCALE $\frac{2}{1}$



DEVELOPED DEPTH OF NOTCH IN BODY .125



METHOD USED TO SHAPE FORMING TOOL



SECTION D-D
SCALE $\frac{2}{1}$

BODY, M.
STEEL-W
FINISH
MANUFACTURING

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

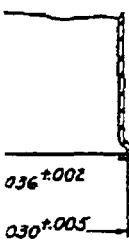
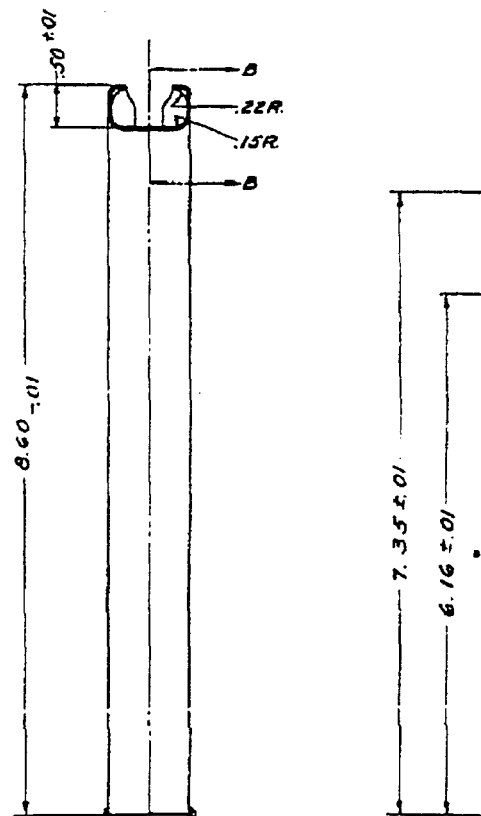
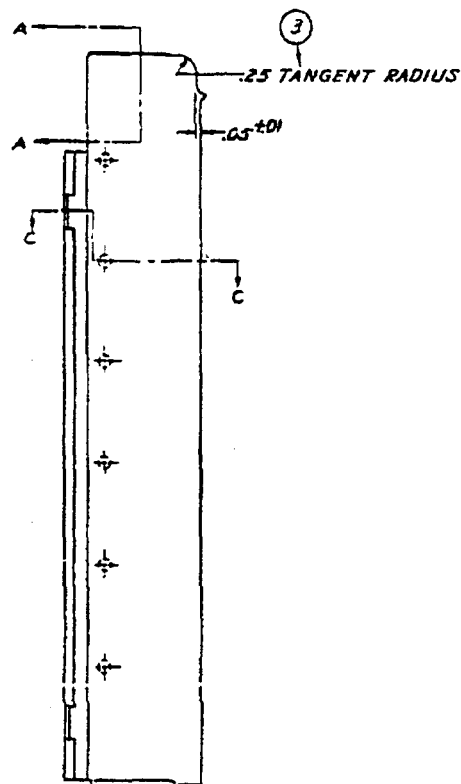
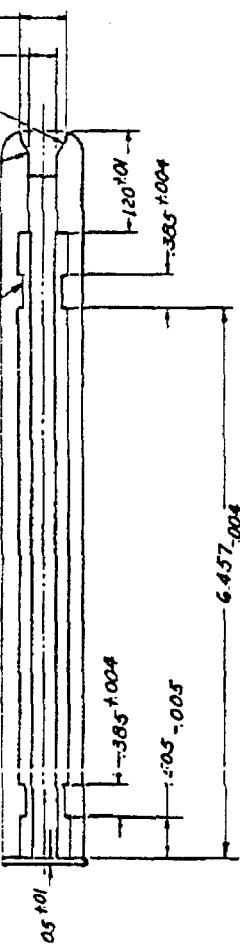
MUST BE SMOOTH HERE
BREAK SHARP CORN

FORMING TOOL

SECTION B-B WITH FORMING TOOL

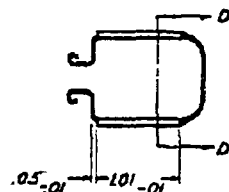
SECTIONAL VIEWS SHOWING METHOD OF USING
FORMING TOOL TO SHAPE MOUTH OF MAGAZINE BODY

SCALE $\frac{2}{1}$

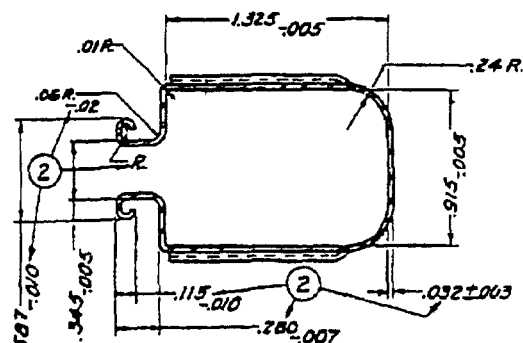


SECTION D-D

SCALE $\frac{2}{1}$



6535507 3 4
BODY, MAGAZINE 35507 1 2
STEEL-W.D. 1025
FINISH
MANUFACTURING COMPONENT



SECTION C-C

SCALE $\frac{2}{1}$

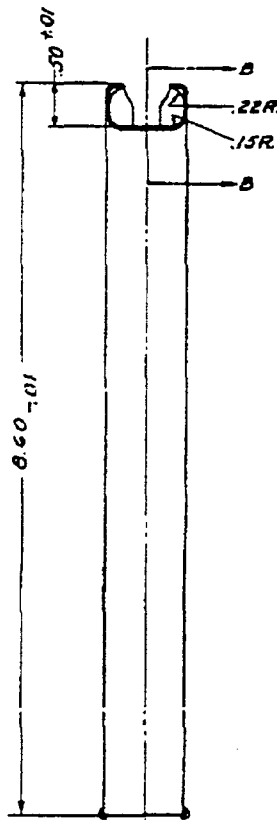
SCA

D6535507

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
HT. T	
BR.	
SCL.	
C. C.	

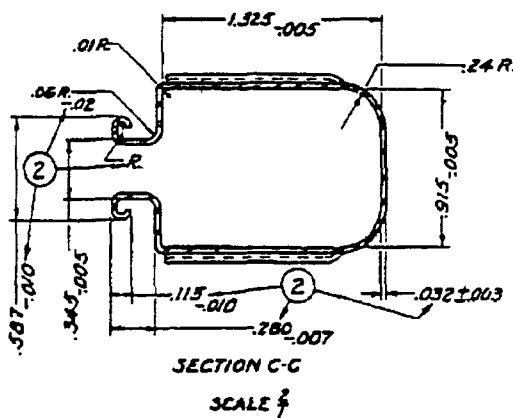
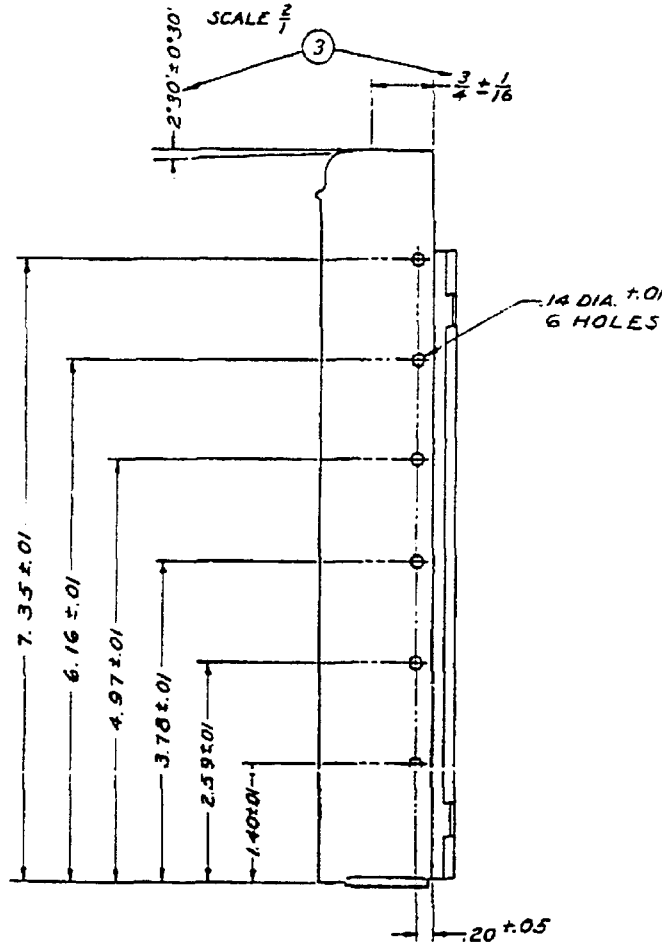
06535507

CENT RADIUS



SECTION A-A

SCALE $\frac{2}{1}$



REF. DRG. S.A. 15305

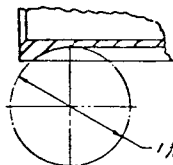
DEC. 20, 1941			CLASS			DIVISION			DRAWING FILE		
REVISIONS						SYMBOL					
1 st 2-11-42											
2 nd 4-16-42											
3 rd 5-18-43											
4 th 8-9-43											
5 COMPARISON 10-30-51						DFTSMAN					
						TRACER			L'DG. DFTSMAN		
						H.M.F.			G.J.A.		
						CHECKER			CHIEF DFTSMAN		
						C.A.M.			J.S.A. 10-30-51		
SUBMITTED:- 20/ (melli) J. L. J.						L.T.COL. ORD. DEPT. U.S.A.					
						EXAMINED:-					
DRG. PERTAINS TO						CAPTORD. DEPT. U.S.A.					
013304 MAGAZINE, BOX,						APPROVED BY ORDER OF THE CHIEF OF ORDNANCE M. J. K. K. K. CAPT ORD. DEPT. U.S.A.					
30 CARTRIDGE											
643364 TUBE, MAGAZINE, ASSEMBLY											
D-35507						ORDNANCE OFFICE, WAR DEPT.					

SUPERSEDES D35507

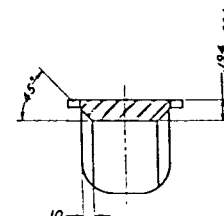
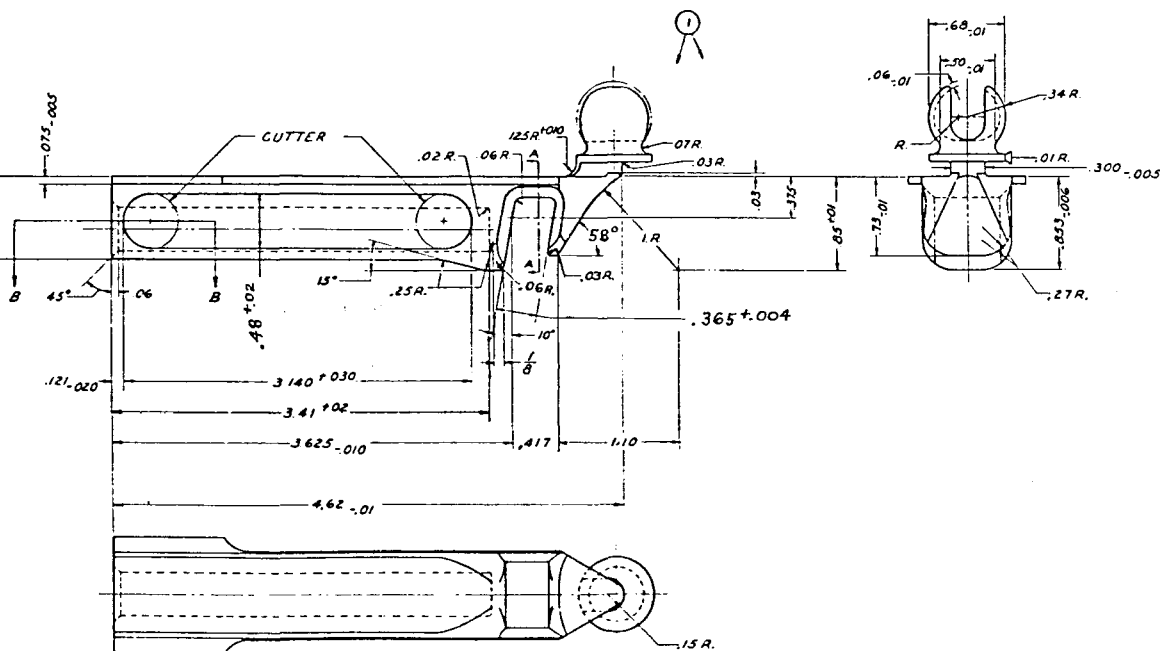
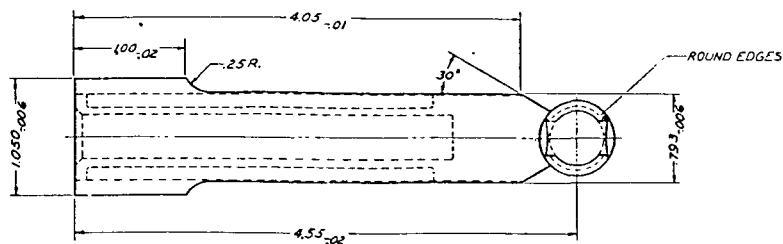
06535507

SCALE $\frac{1}{2}$

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL-2	
RED.	
HT. T	
BR.	
SCL	
C. C.	

[illegible]

- 1 $\frac{1}{16}$ - $\frac{1}{16}$ CUTTER



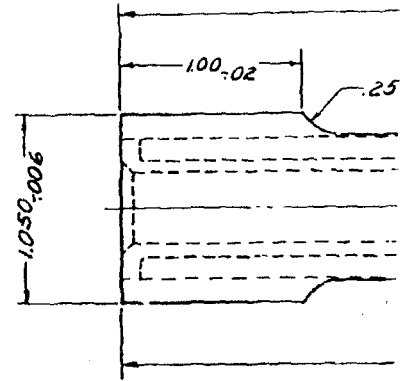
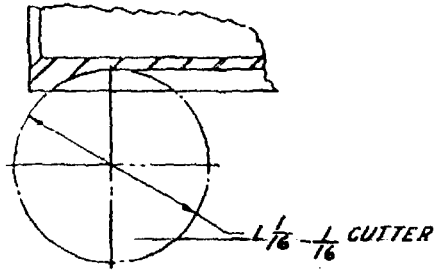
SECTION A-A

ACTUATOR (D-35508)
FINISH 6535508

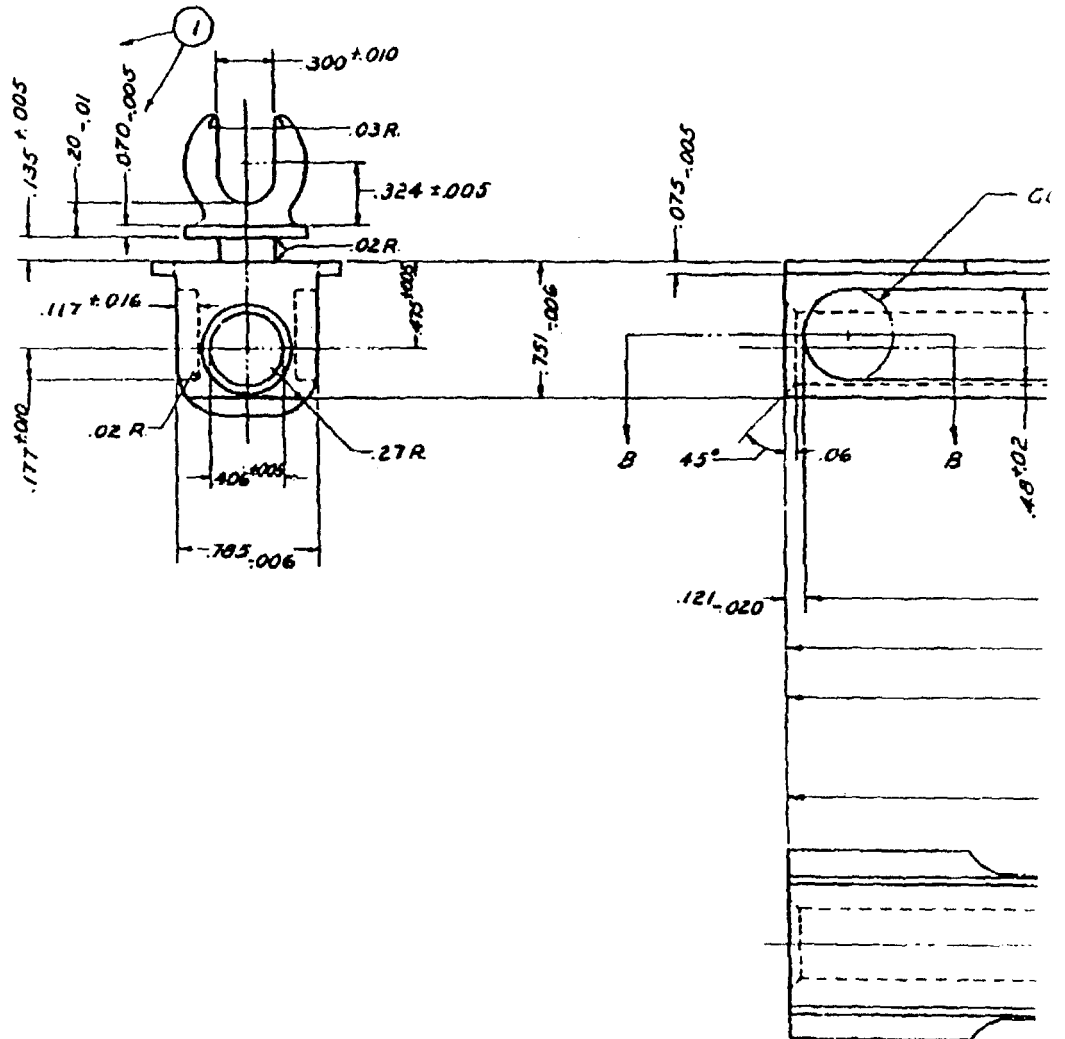
REF. DRG. A.O.C. 45-G-22

DEC 31, 1941		CLASS	DIVISION	DRAWING	FILE
REVISONS					
1/12/30-41 2 1/12/30-41 10-10-41		SYMBOL			
		DESIGNER TRACER CHECKER <i>W. H. H. H. H.</i> DATE <i>1/10/42</i>		L.D. OFFICIAL <i>W. H. H. H. H.</i> CHECKED OFFICIAL <i>W. H. H. H. H.</i>	
		SUBMITTED.			
		<i>INDEXED</i> LT COL ORD DEPT USA			
DRG PERTAINS TO		EXAMINED.			
31-63 45 JMG-M28A1		ORD DEPT USA APPROVED: <i>W. H. H. H. H.</i> (1-10-42)			
		<i>Ref. sent</i> LT COL ORD DEPT USA			
D-35508		ORDNANCE OFFICE, WAR DEPT.			
		SUPERSEDES D35508			

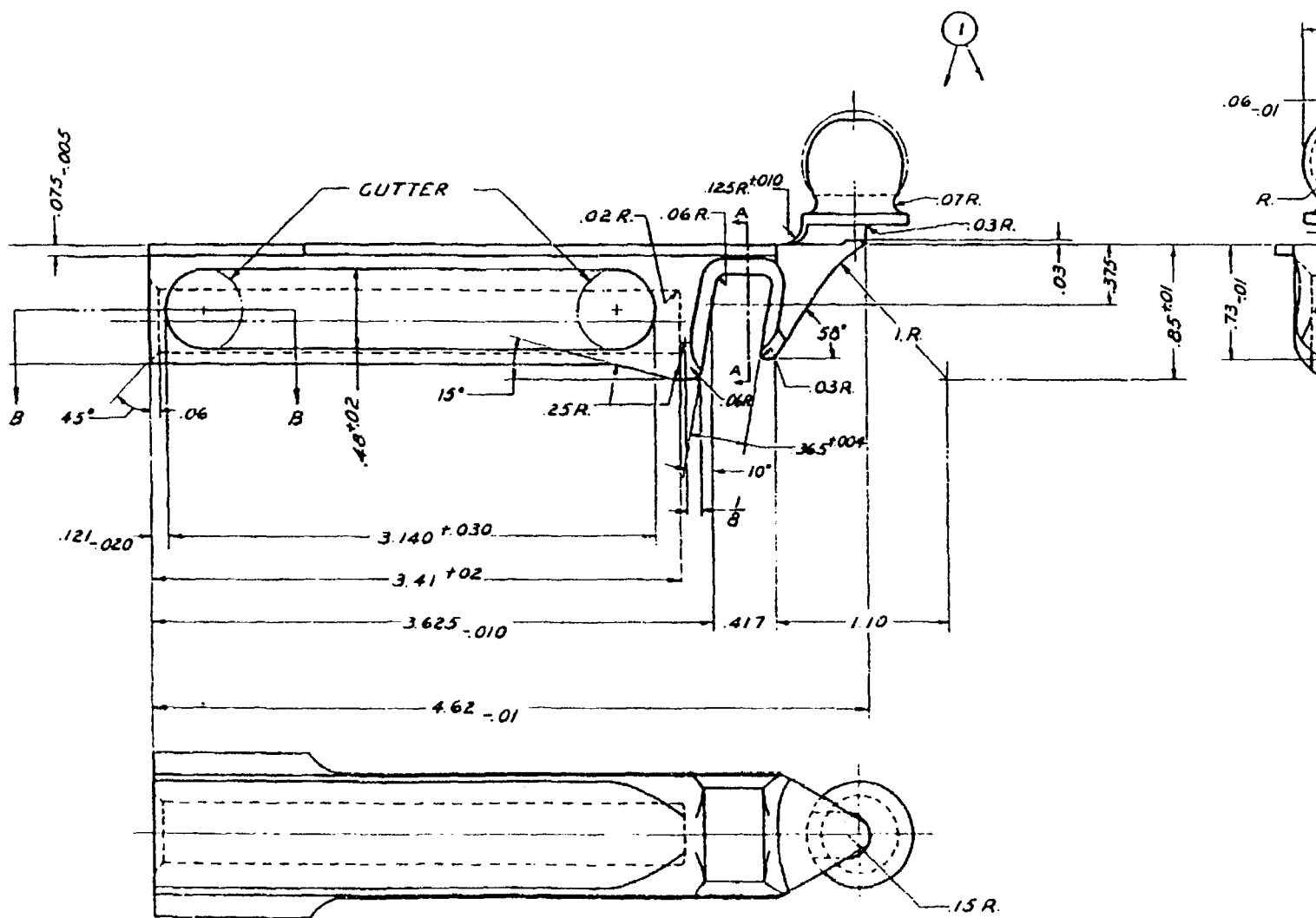
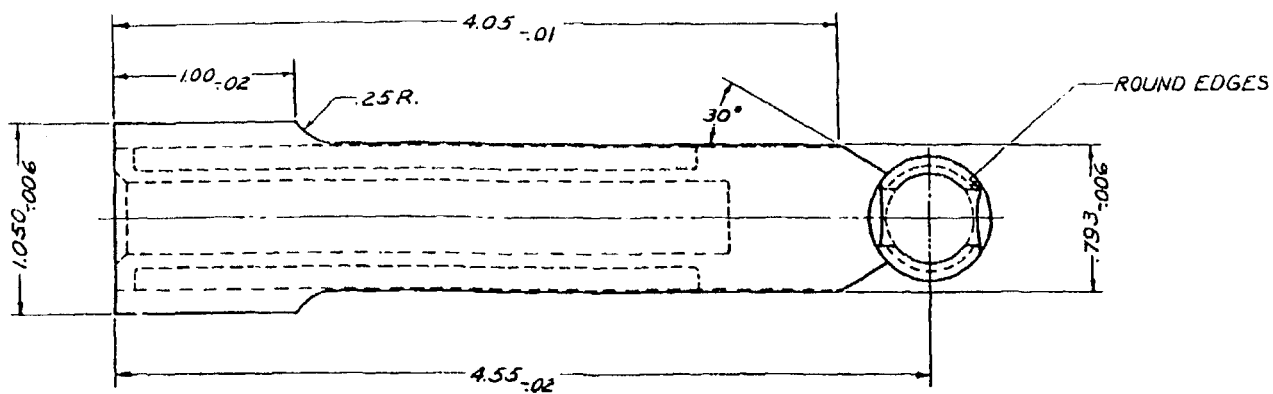
HEAT TREATMENT & FINAL FINISH



SECTION THRU B-B
SHOWING OPTIONAL METHOD OF
MILLING LIGHTENING CUTS.



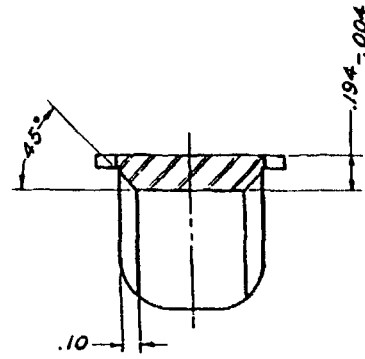
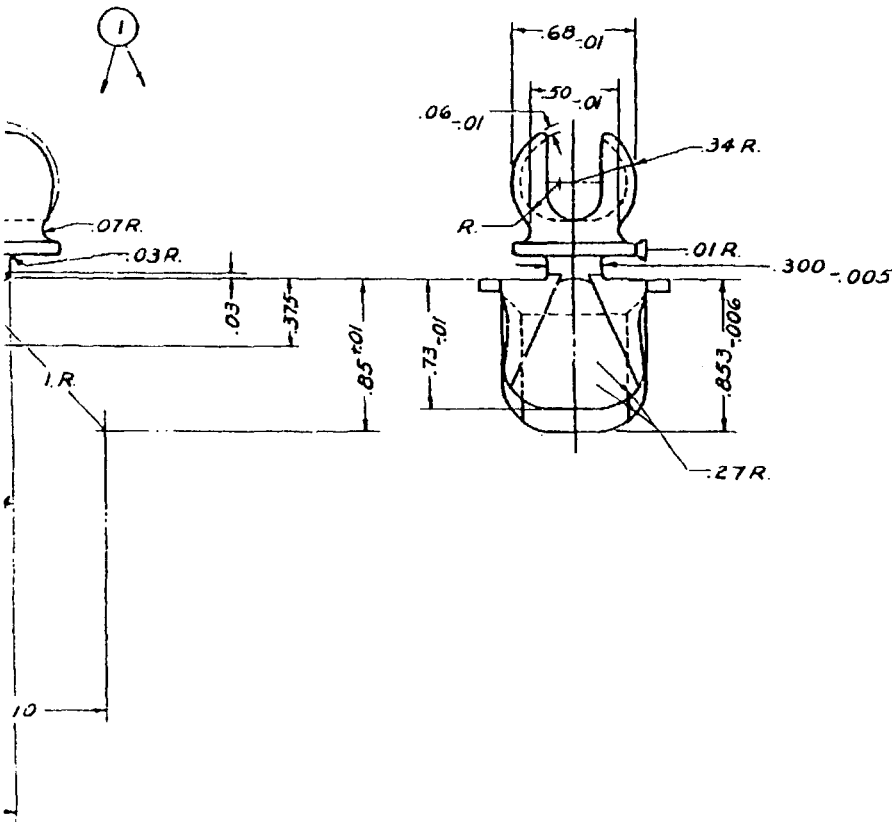
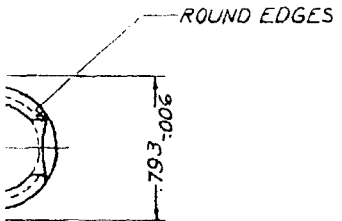
TOLERANCE ±.005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



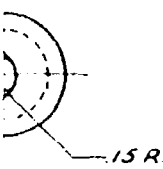
ACTUATOR \oplus
FINISH $\frac{F}{3}$

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL-2	
RED.	
HT. T.	
BR.	
SCL.	
C. C.	

76535508



SECTION A-A



ACTUATOR (1)
FINISH "F" 6535508

REF. DRG. A.O.C. 45-G-22

DEC. 31, 1941		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	12-30-41				
2	10-30-41				
SYMBOL					
DFTSMAN	TRACER	L'D.G. DFTSMAN			
W. J. M.	H. M. F.	G. J. G.			
CHECKER	6th	CHIEF DFTSMAN			
SUBMITTED:		7/24/41			
ORG. PERTAINS TO		LT. COL. ORD. DEPT. U.S.A.			
51-63	45 SMG-M2B A1	EXAMINED:			
		ORD. DEPT. U.S.A.			
		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE			
		John W. Smith COL. ORD. DEPT. U.S.A.			
D-35508		ORDNANCE OFFICE, WAR DEPT.			
SUPERSEDES D35508					

SCALE 2/7
D6535508

1.005 DIA

Technical drawing of a shaft. The shaft has a threaded section on the left and a smooth section on the right. A dimension line indicates a length of $10.53 \pm .06$ for the smooth section. A section line A-A is shown on the right end of the shaft.

PHYSICAL PROPERTIES	
Y P	
T S	
EL 2	
RED	
HT T	
BR	
SCL	
C C	

5	5
-	5
	5
	5

3 { MAJOR DIA. .7500-.0062
PITCH DIA. .7268-.0030
MINOR DIA. .7062 MAX

(A) BASIC MIN. FOR DETERMINING BODY AND BULLET SEAT.
(B) BASIC MIN. DIA. FOR DETERMINING BODY
(C) BASIC MIN. DIA. FOR DETERMINING BULLET SEAT.

CHAMBER DETAILS
SCALE $\frac{4}{1}$

Technical drawing of a ring (Fig. 1). The drawing shows a cross-section of a ring with a central hole. The outer diameter is dimensioned as 1.47 ± 0.03 . The inner diameter is dimensioned as $+0.03$. The ring is labeled with a circled 5 and a circled 1. The material is identified as 441 and 449, with a thickness dimension of $+0.03$.

SECTION A-A
SCALE $\frac{4}{1}$

RIFLING: 6 GROOVES. 1 TURN IN 16 INCHES. R.H.
UNIFORM TWIST

BARREL (E)
FINISH F
MANUFACTURING COMPONENT

© ~~35509~~
6535509

BARREL WITHOUT FINS ———— (C)
OPTIONAL DESIGN
SCALE 4
NOTE: ALL DIMENSIONS NOT NOTED ARE TO
BE THE SAME AS THOSE SHOWN ON THIS
DRAWING FOR THE BARREL WITH FINS.

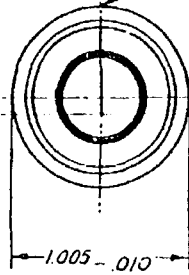
REF DRG AOC. 45-1-1

DEC. 31, 1941	CLASS	DIVISION	DRAWING	FILE
REVISONS				
1 st 2-11-42	SYMBOL			
2 nd 10-7-42				
3 rd 6-5-43				
4 th 7-17-43				
5 th 7-18-43				
6 th 7-18-43	OFFSMAN	FRACER	1 st DIST. OFFSMAN	
	CHICKER	1 st DIST. OFFSMAN	BUICK OFFSMAN	
	SUBMITTED	1 st DIST. OFFSMAN	1 st DIST. OFFSMAN	
	1 st DIST. OFFSMAN			
ORG. PERTAINS TO	LT. COL. ORG. DEPT. U.S.			
51-63 455MG. - M-20A1	EXAMINED -			
ENGINE RECIPIENT IN BARREL	OR ORG. DEPT. U.S.			
ASSEMBLY	OR ORG. DEPT. U.S.			
	OR ORG. DEPT. U.S.			
D-35509	OR ORG. DEPT. U.S.			

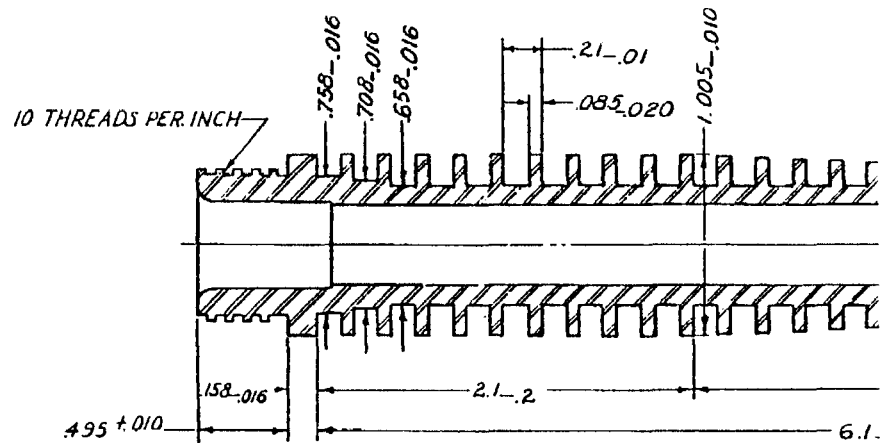
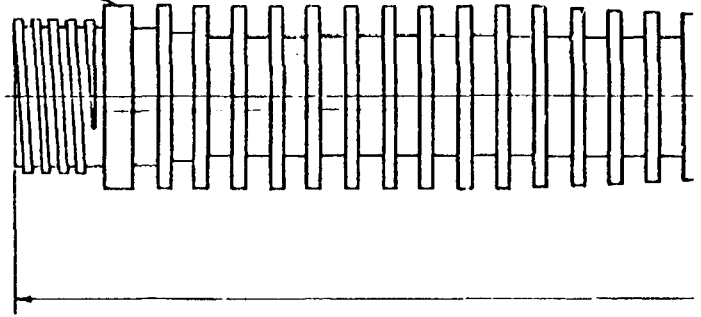
SCALE 4
D6535509

TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

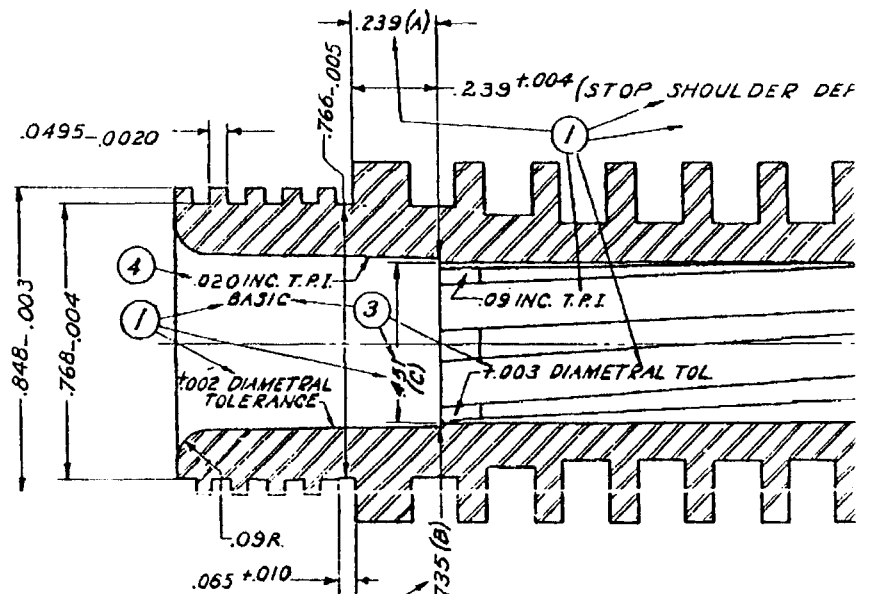
SUPERSEDES 03550



DRAW LINE-MUST MATCH
THREAD QUALIFYING GAGE.
SEE MATING DRAW LINE ON
SIDE OF RECEIVER-D.35512



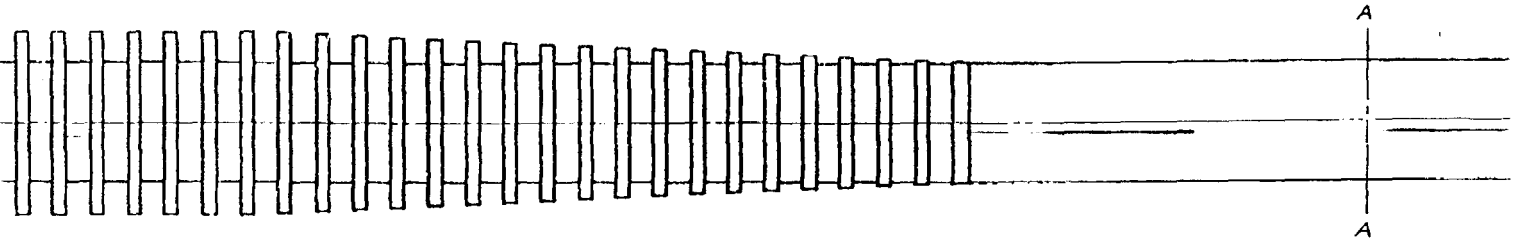
①



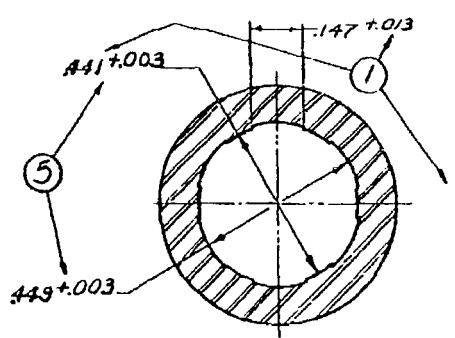
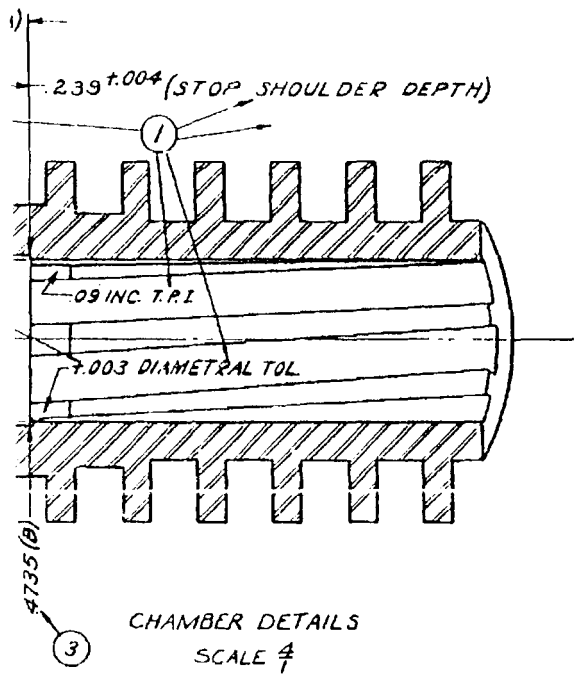
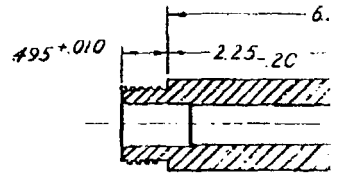
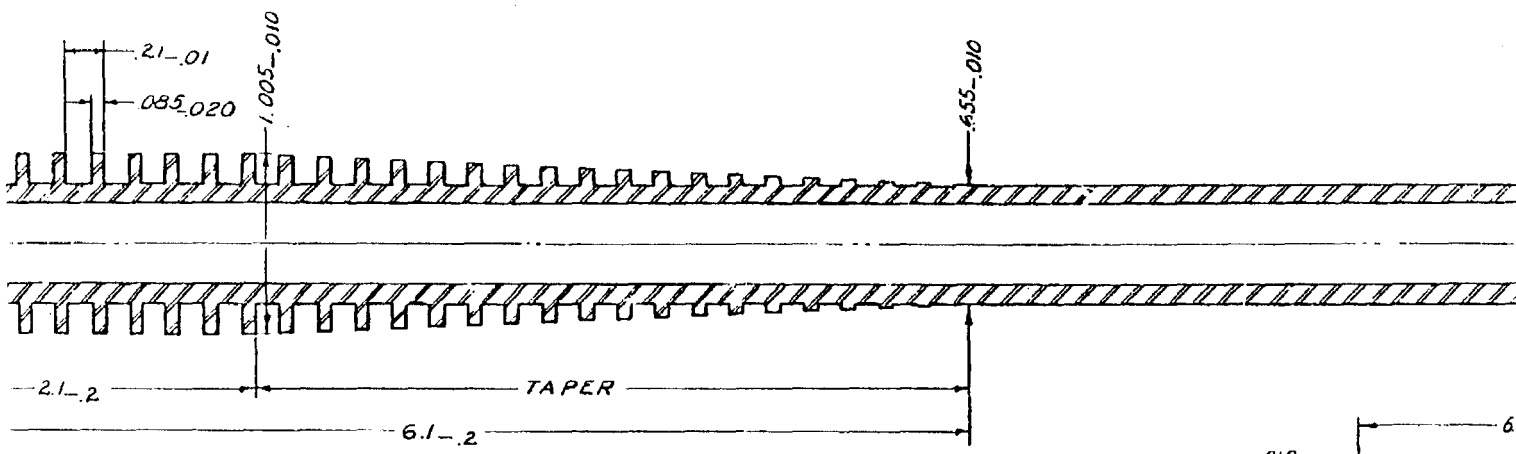
CHAMBER DETAILS
SCALE 4

- (A) BASIC MIN. FOR DETERMINING BODY AND BULLET SEAT.
(B) BASIC MIN. DIA. FOR DETERMINING BODY.
(C) BASIC MIN. DIA. FOR DETERMINING BULLET SEAT.

LATCH
GAGE
ON
3/2



10.53-.06



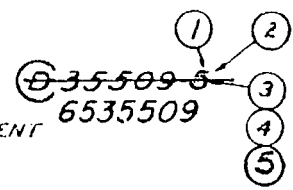
SECTION A-A
SCALE 4

RIFLING: 6 GROOVES. 1 TURN IN 16 INCHES. R.H.
UNIFORM TWIST

N/C
B
D

EAT.

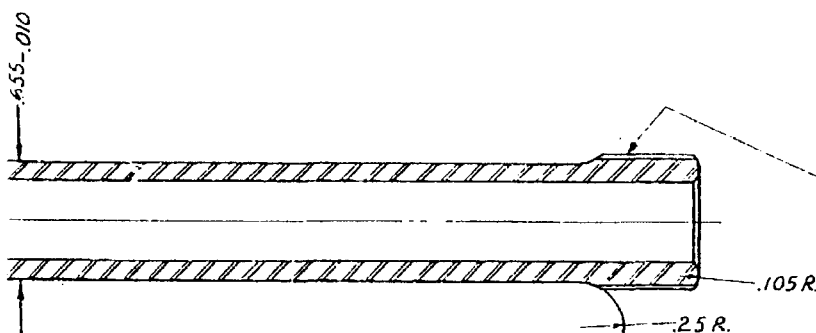
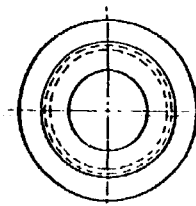
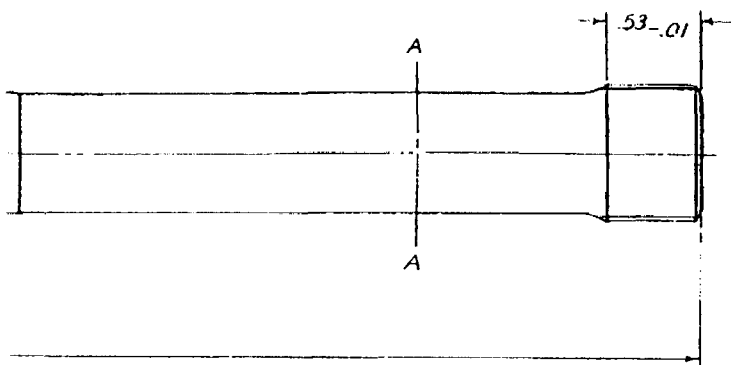
BARREL
FINISH F
MANUFACTURING COMPONENT



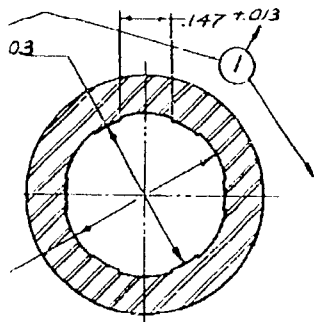
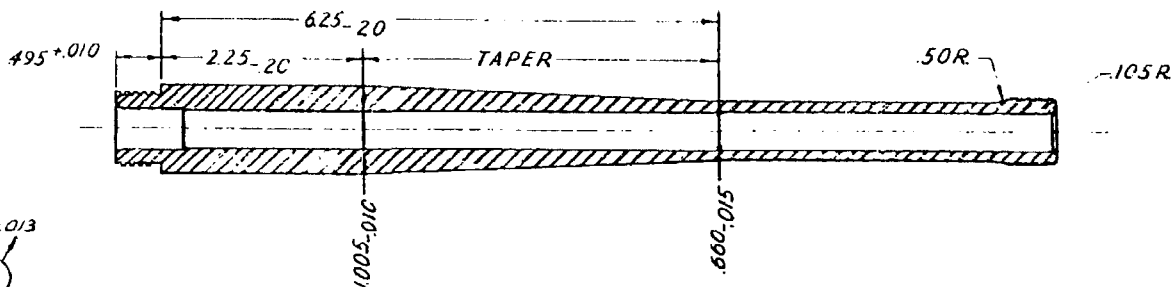
NOTES: TO
REPRODUCE
FROM APT
UNLESS ST.

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
HT. T.	
BR.	
SCL.	
C. C.	

D6535509



MAJOR DIA. .7500-.0062
PITCH DIA. .7268-.0030
MINOR DIA. .7062 MAX.



BARREL WITHOUT FINIS
OPTIONAL DESIGN
SCALE 1/4

NOTE: ALL DIMENSIONS NOT NOTED ARE TO BE THE SAME AS THOSE SHOWN ON THIS DRAWING FOR THE BARREL WITH FINIS.

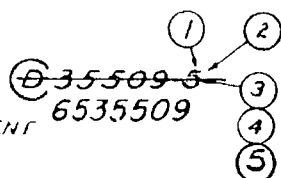
REF. DRG. A.Q.C. 45-1-1

DEC. 31, 1941	CLASS	DIVISION	DRAWING	FILE
REVISIONS				
1 st 8-11-42				
2 nd 10-7-42				
3 rd 6-5-43				
4 th 7-17-43				
5 th 4-10-44				
6 th 12-30-44				
SYMBOL				
DFTSMAN	628	TRACER	628	L'D.G. DFTSMAN
CHECKER	628	CHIEF DFTSMAN	628	CHIEF DFTSMAN
SUBMITTED:				
LT. COL. ORD. DEPT. U.S.A.				
EXAMINED:				
ORD. DEPT. U.S.A.				
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE				
ORD. DEPT. U.S.A.				
ORDNANCE OFFICE, WAR DEPT.				

SECTION A-A
SCALE 1/4

6 GROOVES. 1 TURN IN 16 INCHES. R.H.
UNIFORM TWIST

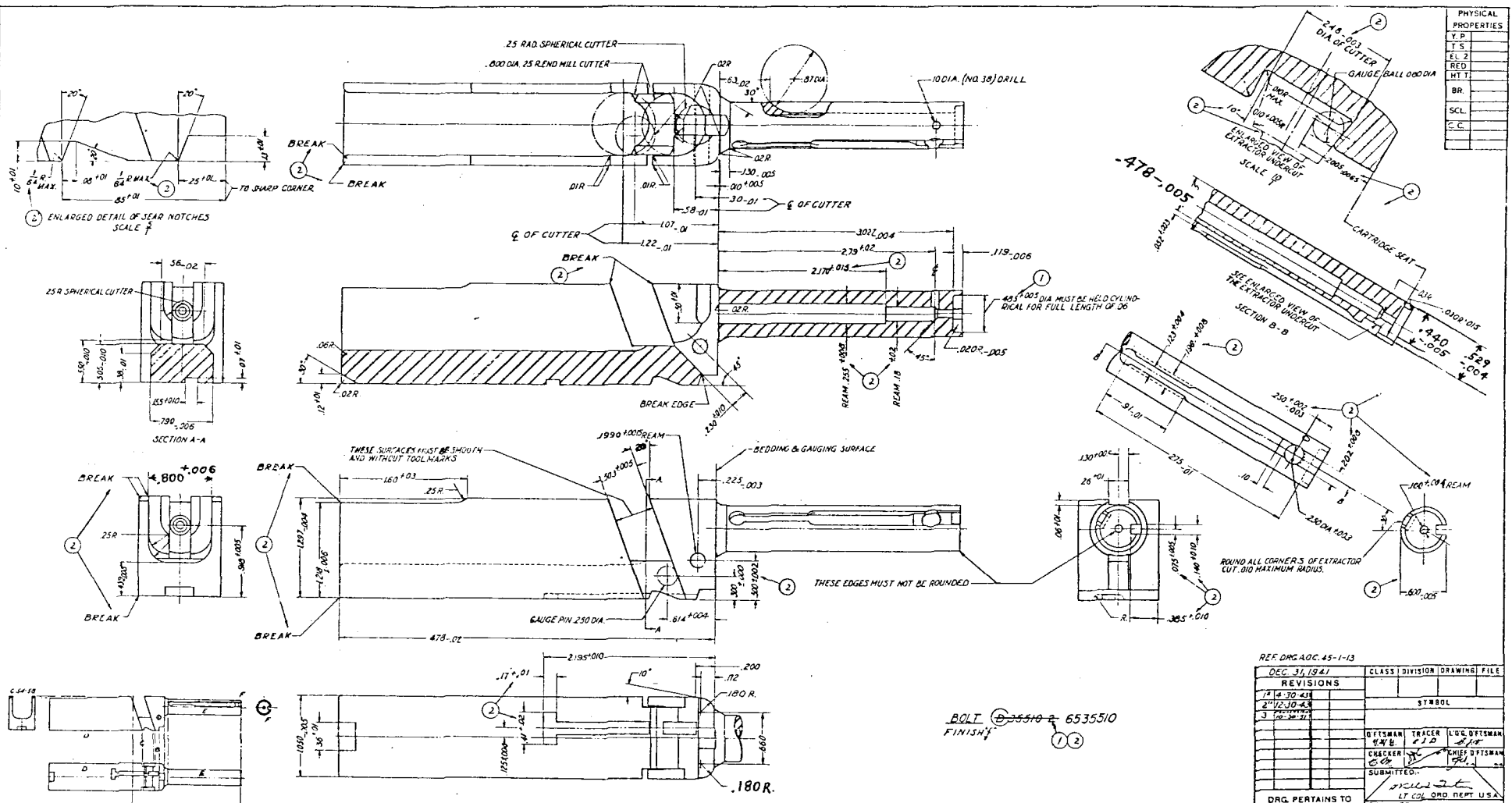
BARREL
FISH F
RING COMPONENT



SCALE 1/4
D6535509

SUPERSEDES D35509

06535510



PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL. 2	
HT. T	
BR.	
SCL.	
C.C.	

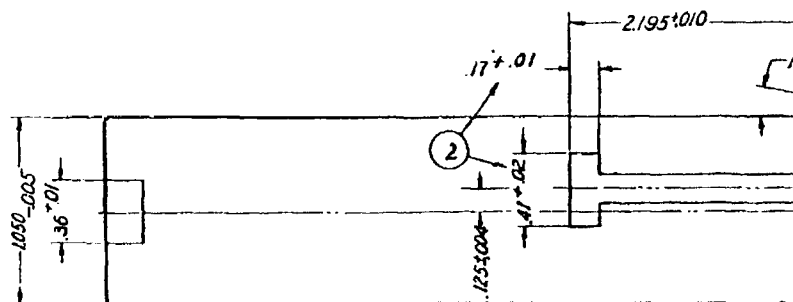
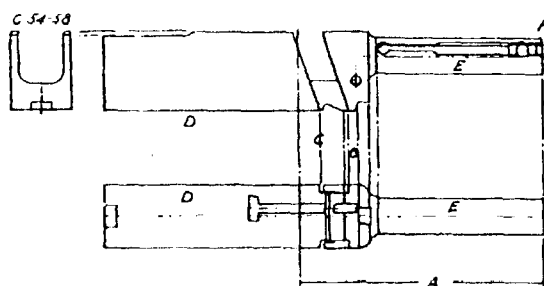
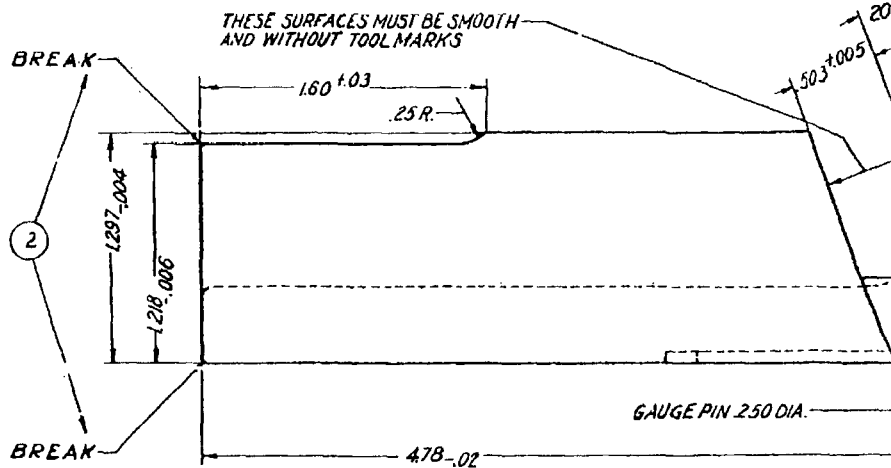
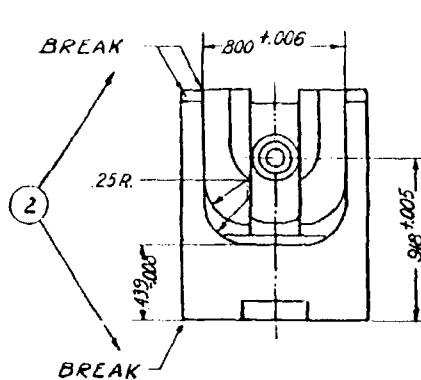
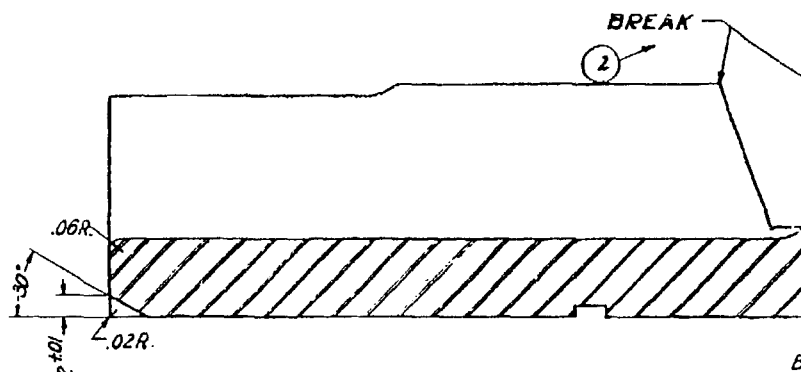
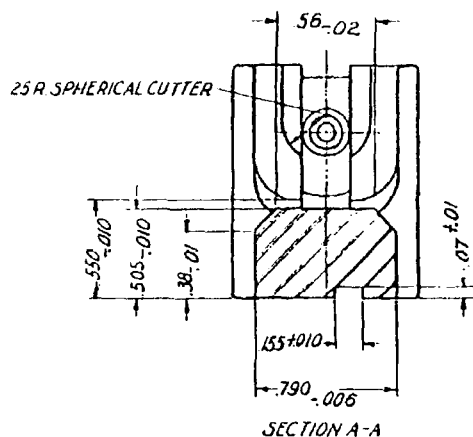
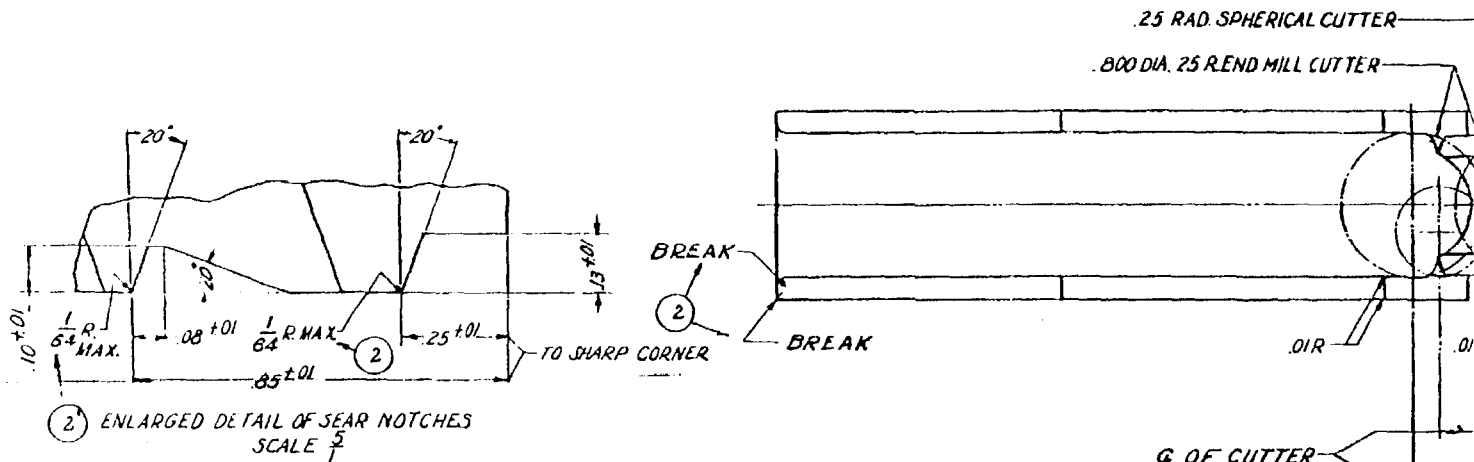
HEAT TREATMENT AND ROCKWELL HARDNESS DIAGRAM
 REFERENCE MATERIAL, HEAT TREATMENT & PROTECTIVE FINISH LIST-3477700

TO EXAMINE: 1.01 ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

BOLT 655510 6535510
 FINISH

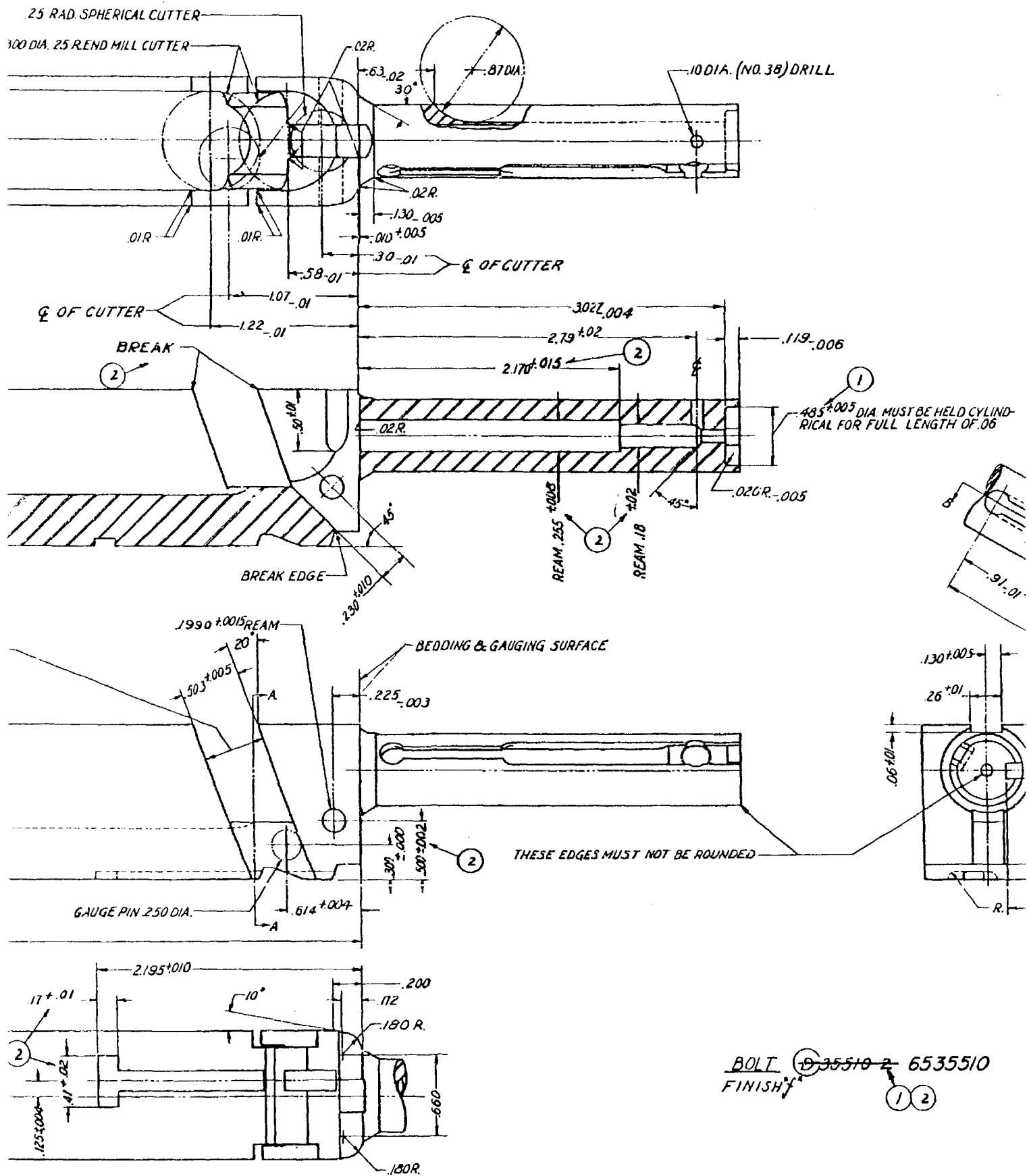
REF. DRG. AOC. 45-1-13	DEC 31, 1941	CLASS	DIVISION	DRAWING	FILE
REVISONS					
1	4-30-43				
2	12-10-43				
3	10-20-51				
SYMBOL					
OFFICER		TRACER		LUG. OFFICER	
CHECKER		CHIEF OFFICER		CHIEF OFFICER	
SUBMITTED					
DRG. PERTAINS TO					
31-6-45 SHS-M28A1					
EXAMINED					
ON. DEPT. U.S.A.					
ORDNANCE OFFICE, WAR DEPT.					
SUPERSEDES D35510					

06535510 SCALE 1/2

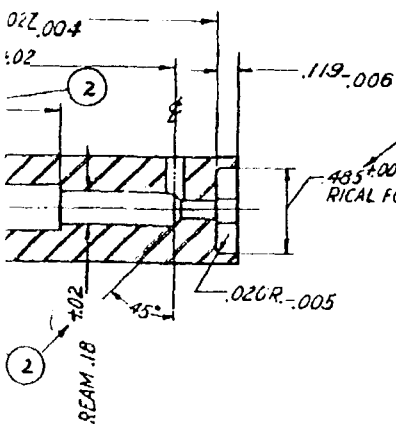
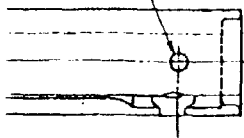


HEAT TREATMENT AND
 ROCKWELL HARDNESS DIAGRAM
 REFERENCE: MATERIAL, HEAT TREATMENT & PROTECTIVE FINISH LIST-B 47707

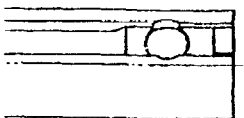
TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.



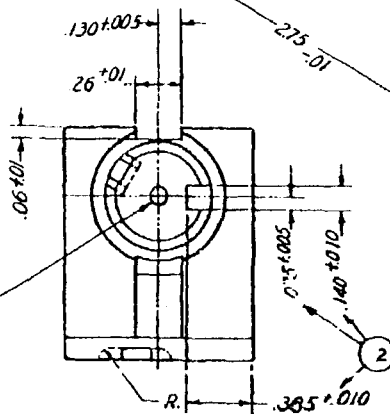
100 DIA. (NO. 38) DRILL



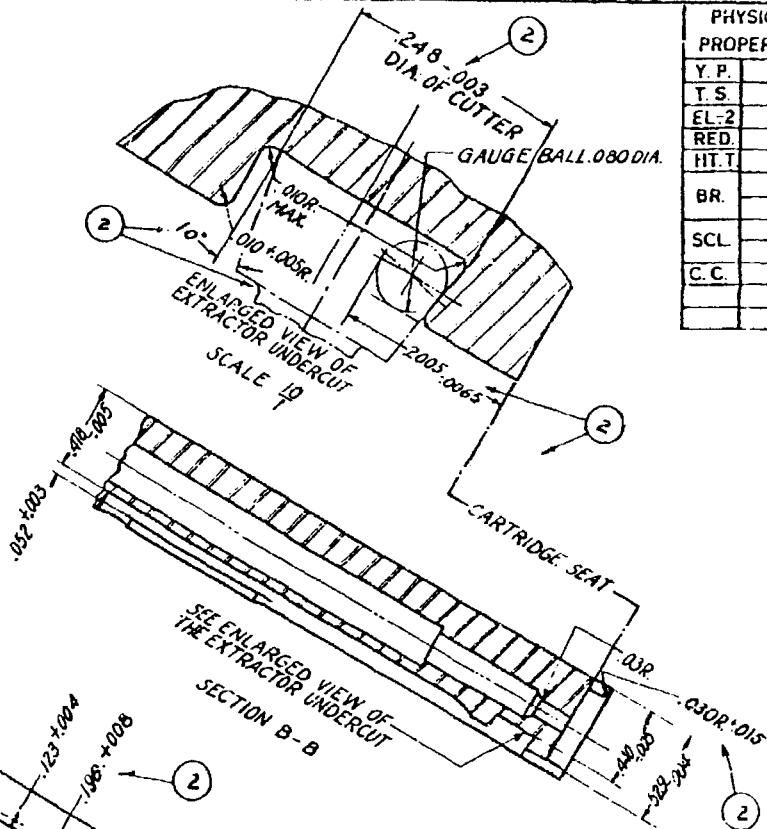
ICE



ES MUST NOT BE ROUNDED



ROUND ALL CORNERS OF EXTRACTOR CUT .010 MAXIMUM RADIUS.



PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
HT. T	
BR.	
SCL.	
C. C.	

BOLT ~~D-35510~~ 2 6535510
FINISH

1 2

REF. DRG. AOC. 45-1-13

DEC. 31, 1941		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	4-30-43				
2	12-30-43				
3	10-30-51				
SYMBOL					
DFTSMAN	TRACER	L'DG. DFTSMAN			
CHECKER	CHK	CHIEF DFTSMAN			
SUBMITTED:					
LT. COL. ORD. DEPT. U.S.A.					
EXAMINED:					
ORD. DEPT. U.S.A.					
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:					
COL. C.P.D. DEPT. U.S.A.					
ORDNANCE OFFICE, WAR DEPT.					

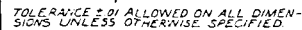
06535510 SCALE 7/8

D-35510

SUPERSEDES D35510

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
HT. T.	
BR.	
SCL.	
C. C.	

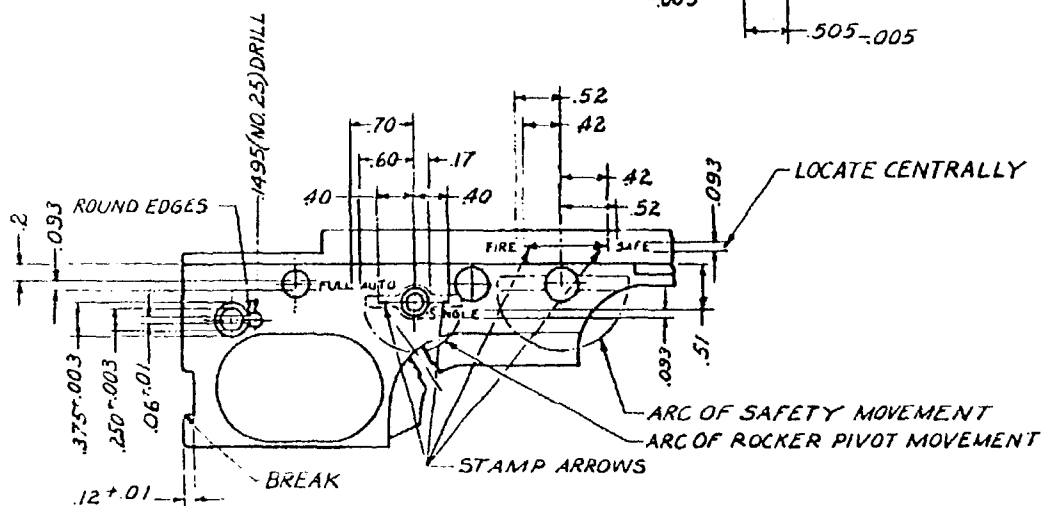
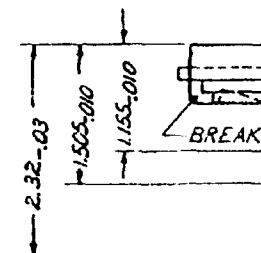
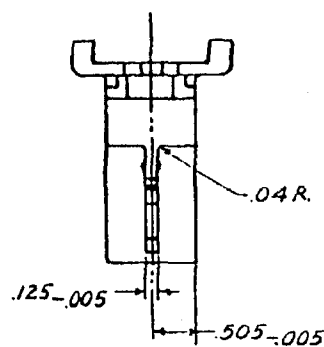
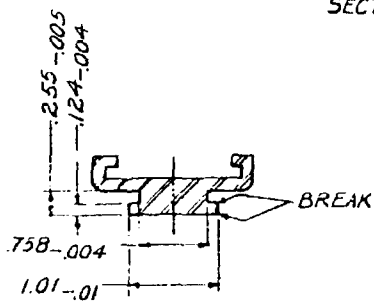
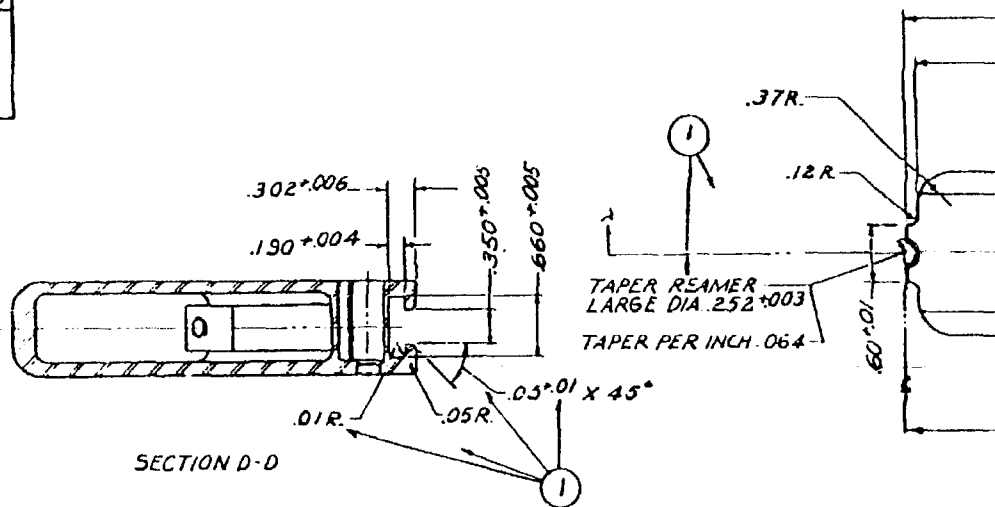
06535511



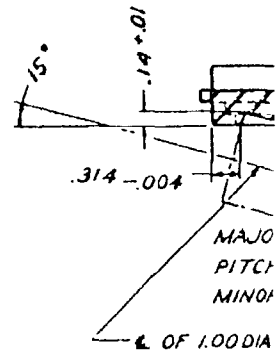
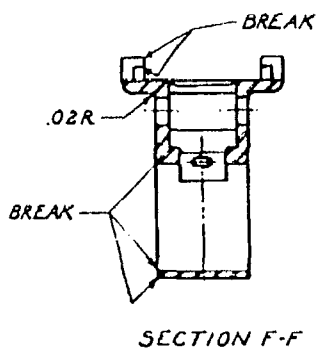
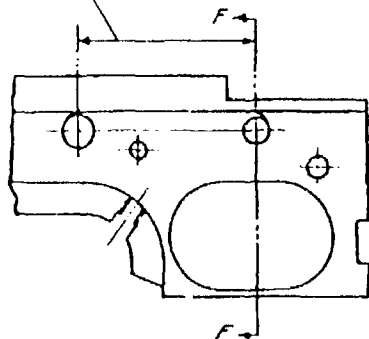
D6535511 SCALE $\frac{1}{1}$

DEC 31, 1941		CLASS		DIVISION		DRAWING		FILE	
REVISONS									
1	12-30-41								
2	12-8-41								
3	12-10-41								
				SYMBOL					
OFFICER				TRACER		LUG OFFICER			
A/C				E/C		B/C			
CHESTER				P/C		CUST OFFICER			
						DEC 31, 1941			
SUBMITTED:									
<i>Miller</i>									
DRG PERTAINS TO				LT COL ORD DEPT. U.S.A.					
S#63 455MG-M28A1				EXAMINED:					
ORD DEPT. U.S.A.									
APPROVED BY REPRESENTATIVE OF THE CAST OF DEFENSE									
<i>J. J. J.</i>									
				POL ORD DEPT. U.S.A.					
D35544				ORDNANCE OFFICE, WAR DEPT.					
SUPERSEDES D35511									

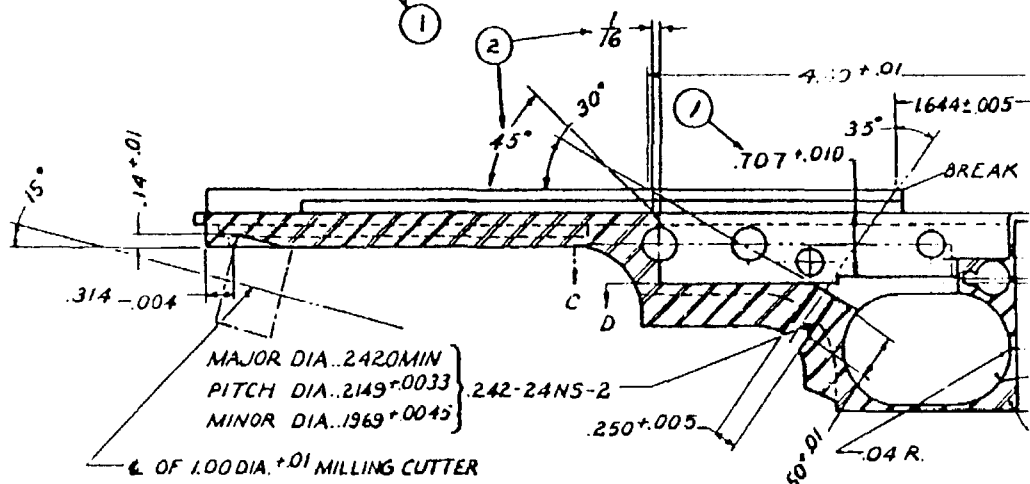
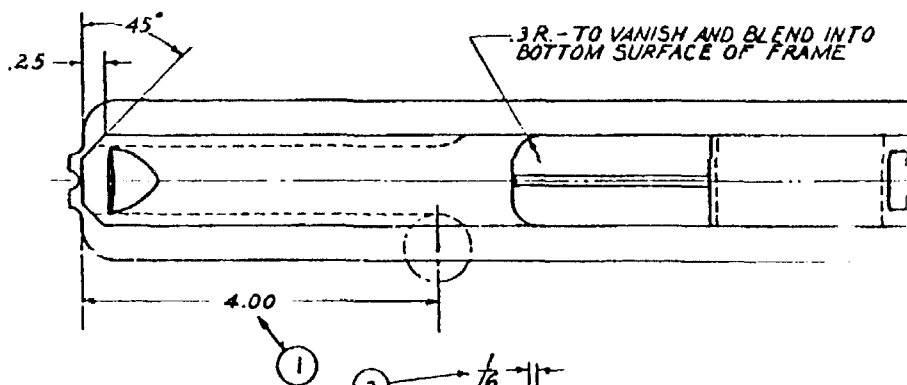
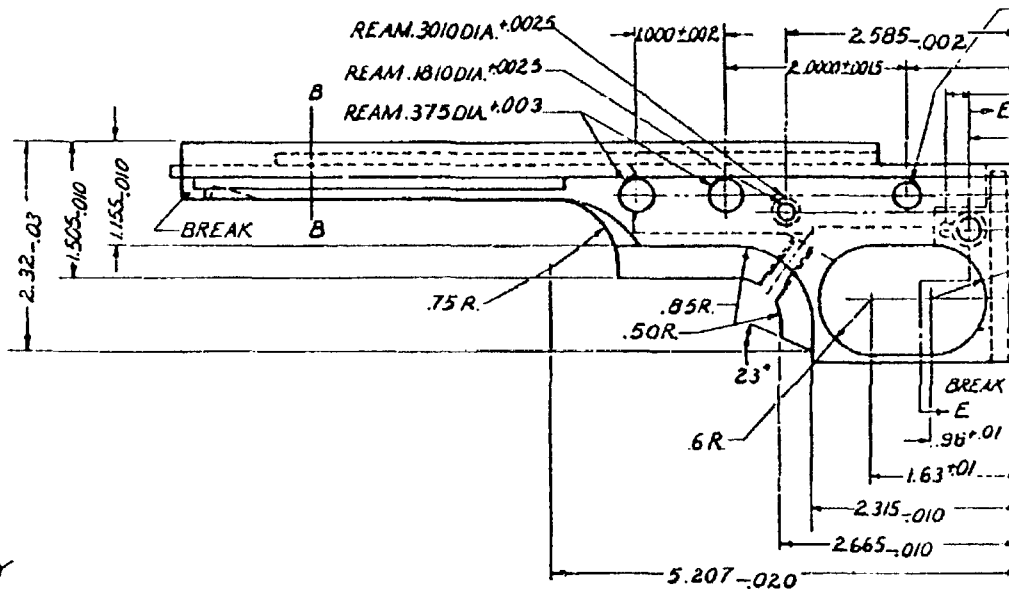
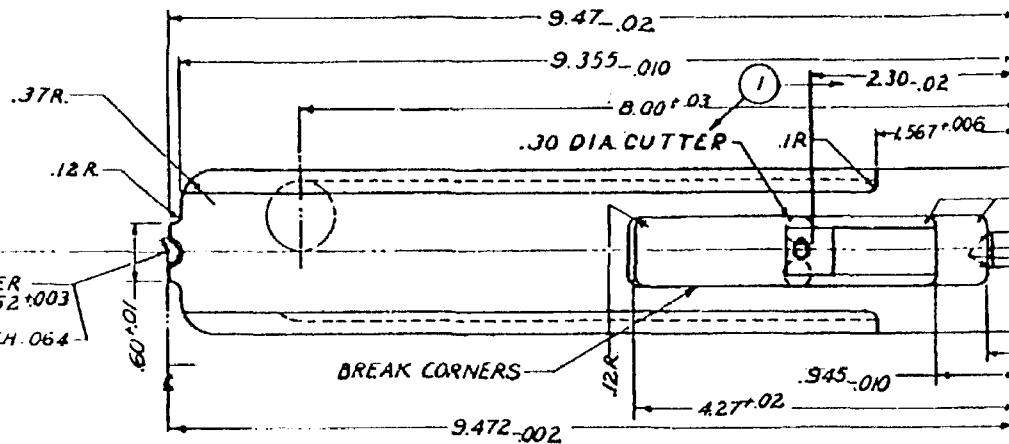
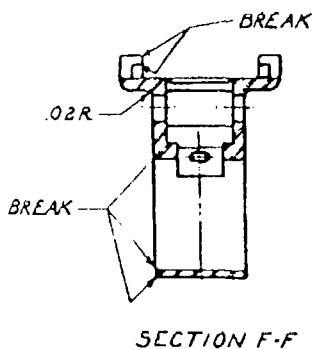
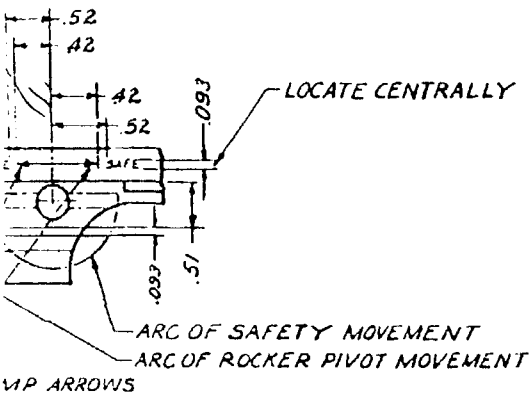
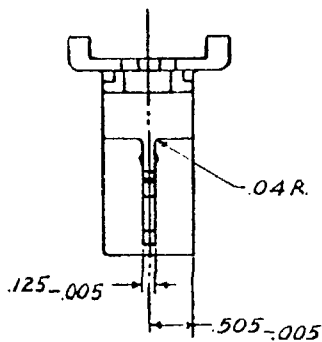
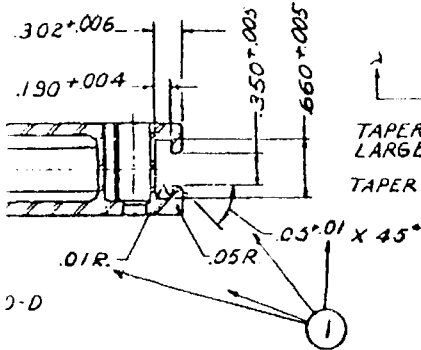
SUPERSEDES 03551



.02 R FILLET BETWEEN
THESE TWO POINTS TO
CLEAR PIVOT PLATE



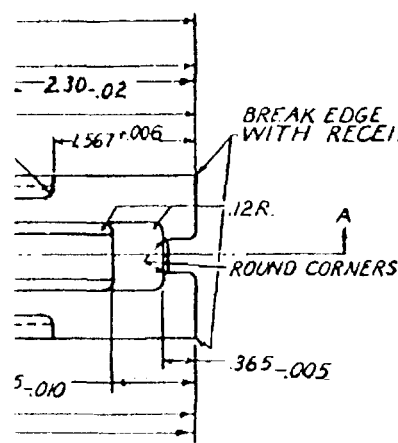
TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS
UNLESS OTHERWISE SPECIFIED.



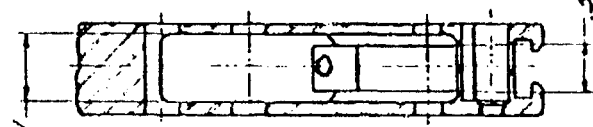
SECTION A-A

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL-2	
RED.	
HT.	
BR.	
SCL.	
C.C.	

06535511

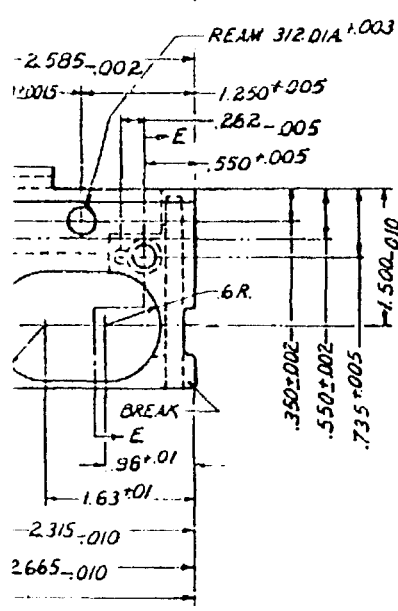


BREAK EDGE TO CORRESPOND WITH RECEIVER

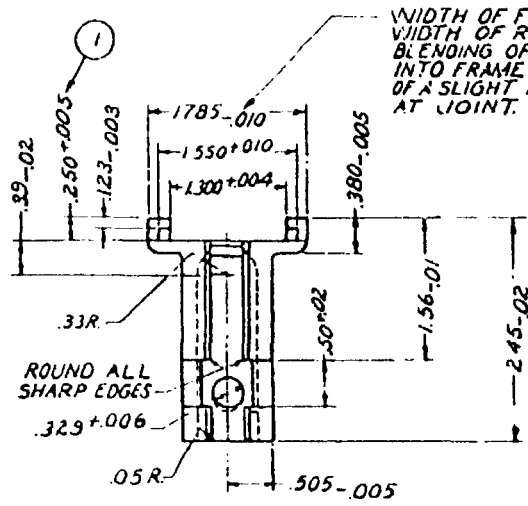


SECTION C-C

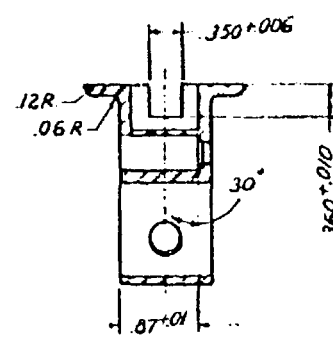
WIDTH OF FRAME IS LESS THAN WIDTH OF RECEIVER, TO ALLOW BLENDING OF RECEIVER SURFACE INTO FRAME SURFACE BY MEANS OF A SLIGHT RADIUS ON RECEIVER AT JOINT.



REAM 3/2 DIA+.003

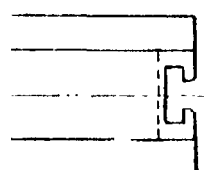


ROUND ALL SHARP EDGES

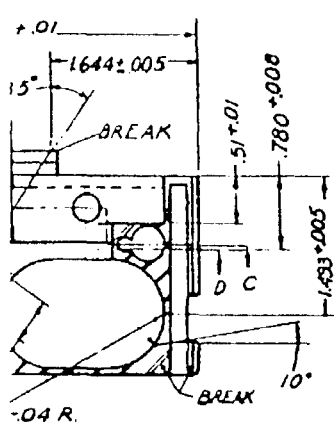


SECTION E-E

BLEND INTO FRAME



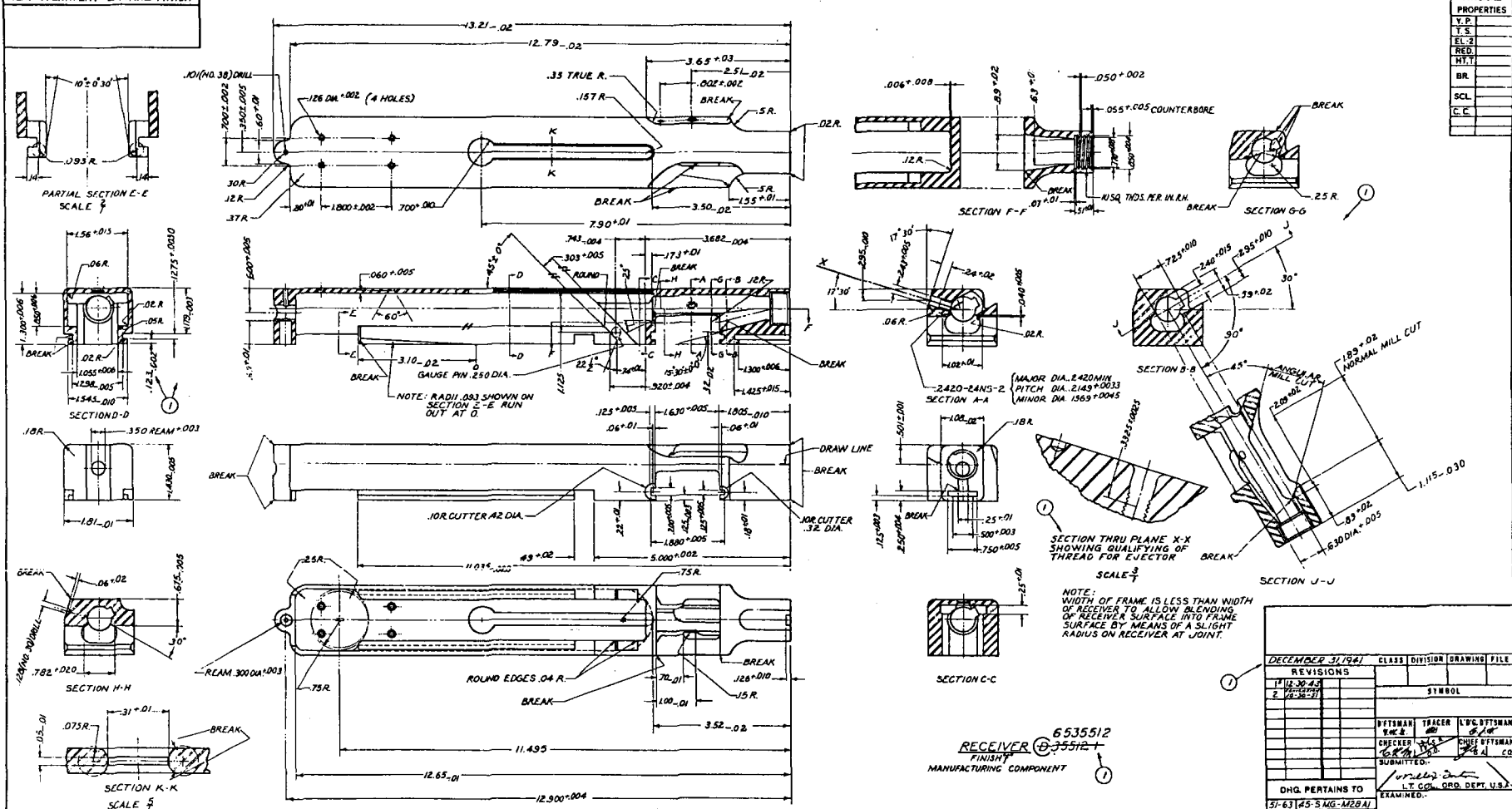
6535511
FRAME ϕ 355H-2
FINISH
1 2



DEC. 31, 1941		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	12-30-41				
2	12-8-44				
3	12-10-51				
SYMBOL					
DFTSMAN		TRACER	C'DG DFTSMAN		
CHECKER			CHIEF DFTSMAN		
SUBMITTED					
DRG PERTAINS TO		LT COL ORD DEPT USA			
51-63 455MG-M28A1		EXAMINED			
		ORD DEPT USA			
		APPROVED BY COMMANDING OFFICER OF COURSE			
		JOHN J. [Signature] COL ORD DEPT USA			
D-355H		ORDNANCE OFFICE, WAR DEPT			
SUPERSEDES D35511					

SCALE
D6535511

HEAT TREATMENT & FINAL FINISH



TOLERANCE ± .005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

RECEIVER 653512
FINISH
MANUFACTURING COMPONENT

REF. DRG. ADC-45-1-2

SCALE 1/8" = 1"

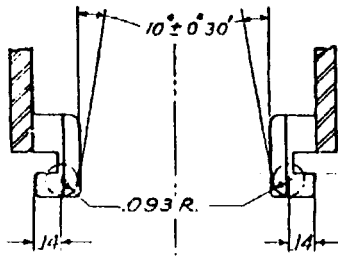
REVISIONS	CLASS	DIVISION	DRAWING	FILE
1. 12-30-43				
2. 12-30-43				
3. 12-30-43				
4. 12-30-43				
5. 12-30-43				
6. 12-30-43				
7. 12-30-43				
8. 12-30-43				
9. 12-30-43				
10. 12-30-43				
11. 12-30-43				
12. 12-30-43				
13. 12-30-43				
14. 12-30-43				
15. 12-30-43				
16. 12-30-43				
17. 12-30-43				
18. 12-30-43				
19. 12-30-43				
20. 12-30-43				
21. 12-30-43				
22. 12-30-43				
23. 12-30-43				
24. 12-30-43				
25. 12-30-43				
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27. 12-30-43				
28. 12-30-43				
29. 12-30-43				
30. 12-30-43				
31. 12-30-43				
32. 12-30-43				
33. 12-30-43				
34. 12-30-43				
35. 12-30-43				
36. 12-30-43				
37. 12-30-43				
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39. 12-30-43				
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41. 12-30-43				
42. 12-30-43				
43. 12-30-43				
44. 12-30-43				
45. 12-30-43				
46. 12-30-43				
47. 12-30-43				
48. 12-30-43				
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99. 12-30-43				
100. 12-30-43				

PHYSICAL PROPERTIES
Y.P.
T.S.
EL. 2
RED.
HT. 1
BR.
SCL.
C.C.

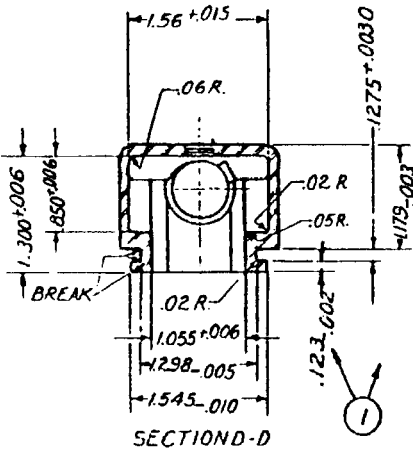
D653512

SUPERSEDES D35512

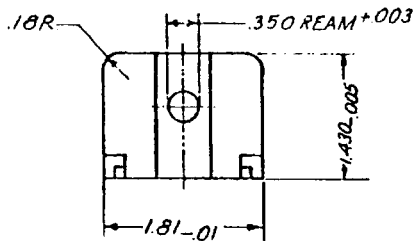
HEAT TREATMENT & FINAL FINISH



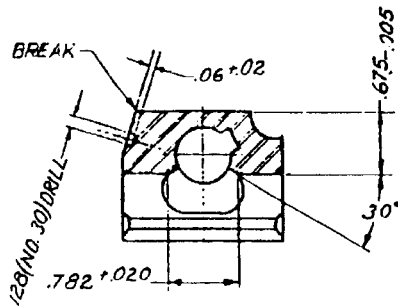
PARTIAL SECTION E-E
SCALE $\frac{2}{7}$



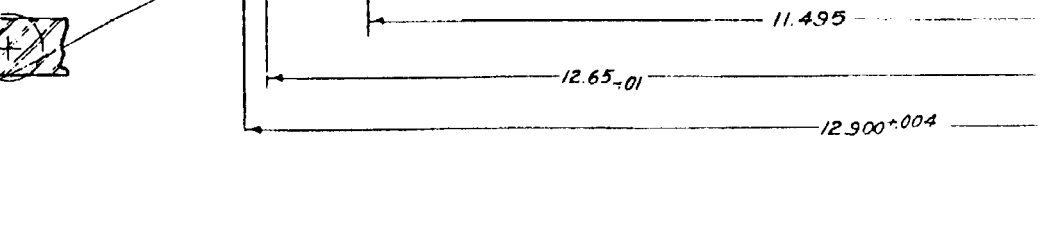
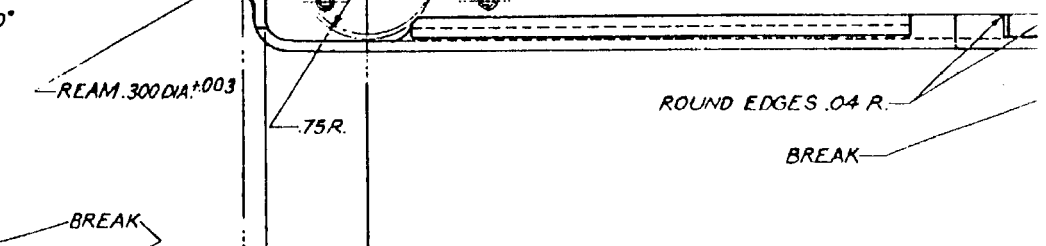
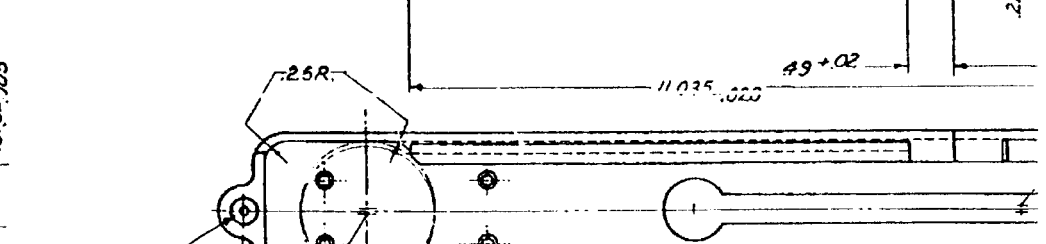
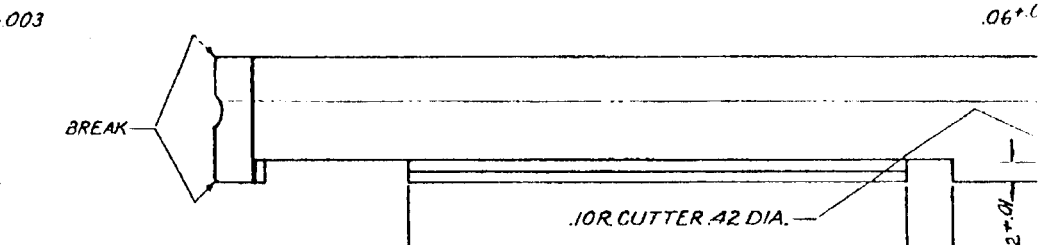
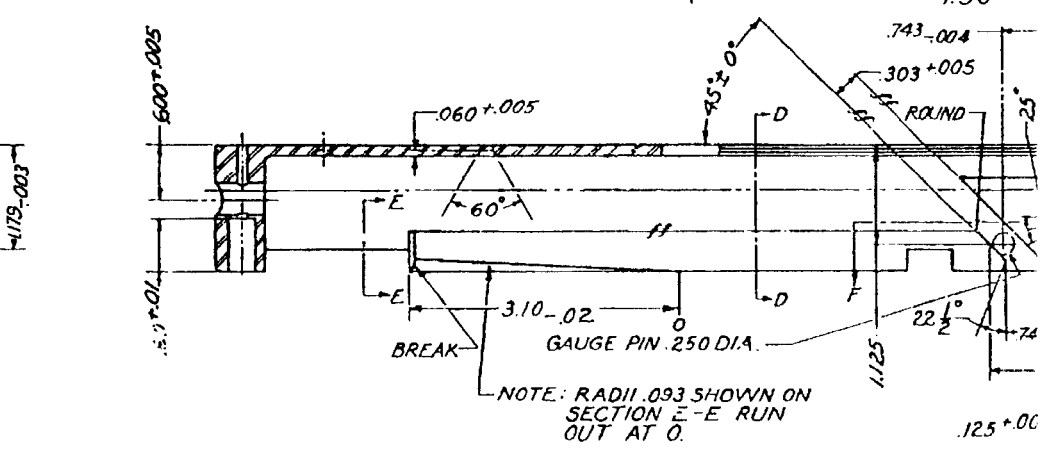
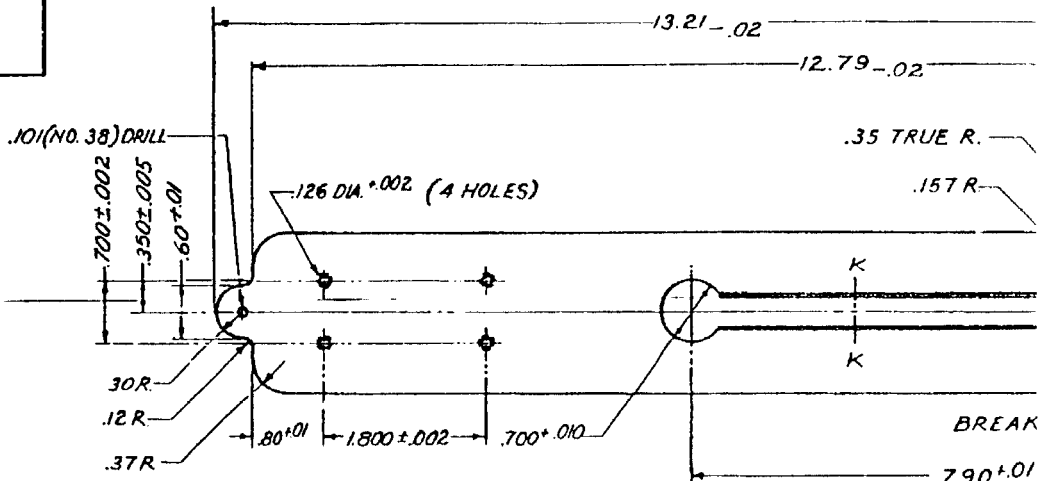
SECTION D-D



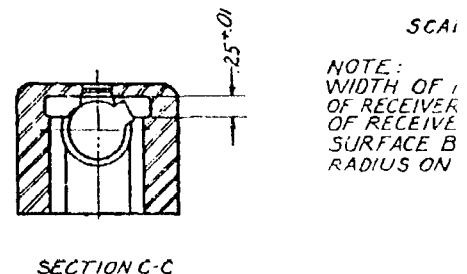
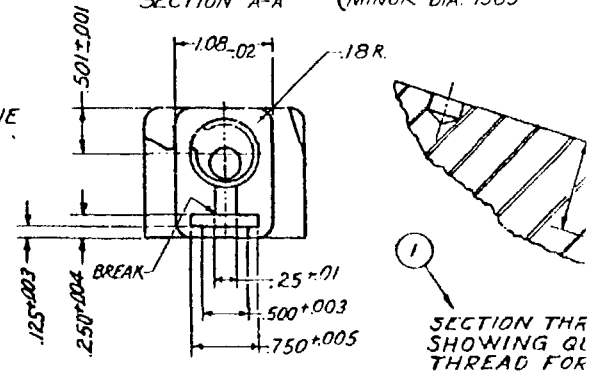
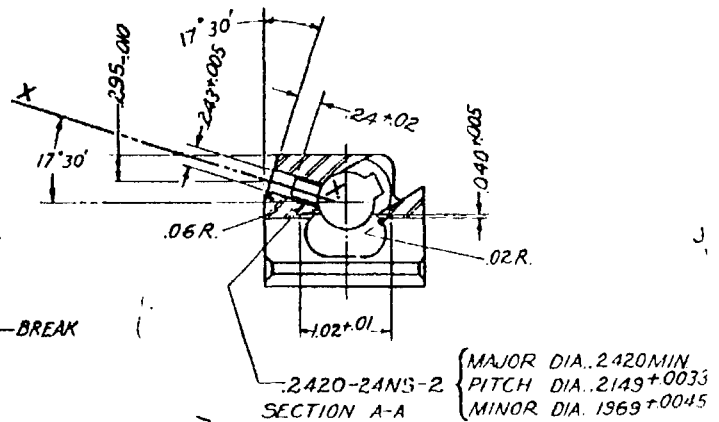
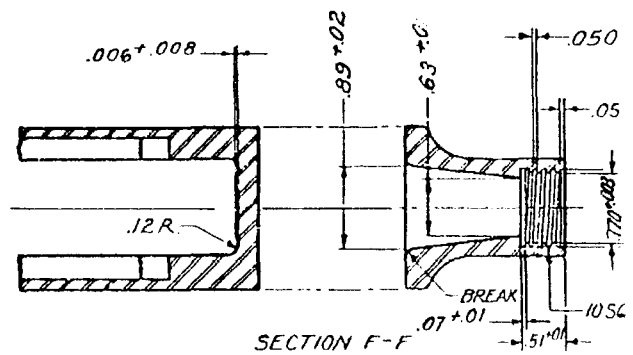
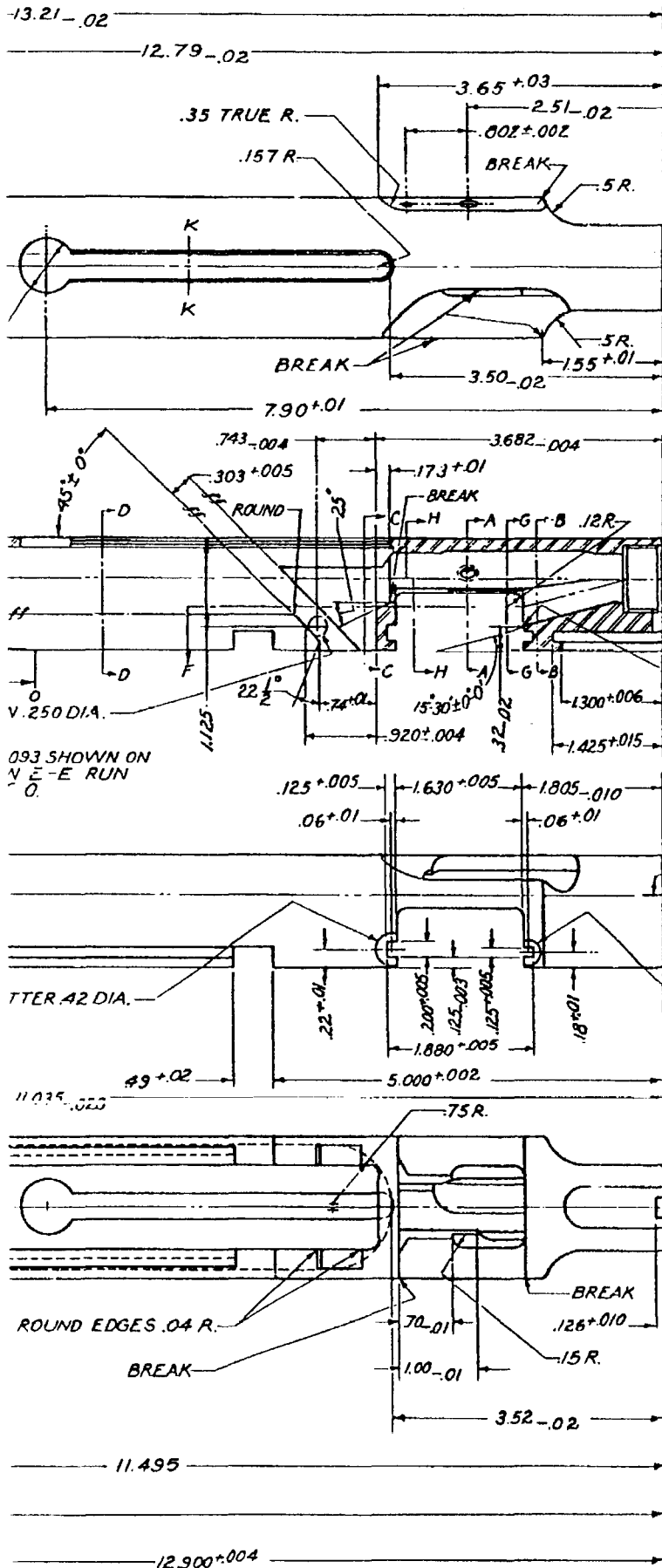
SECTION H-H



SECTION K-K
SCALE $\frac{1}{5}$



TOLERANCE $\pm .005$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

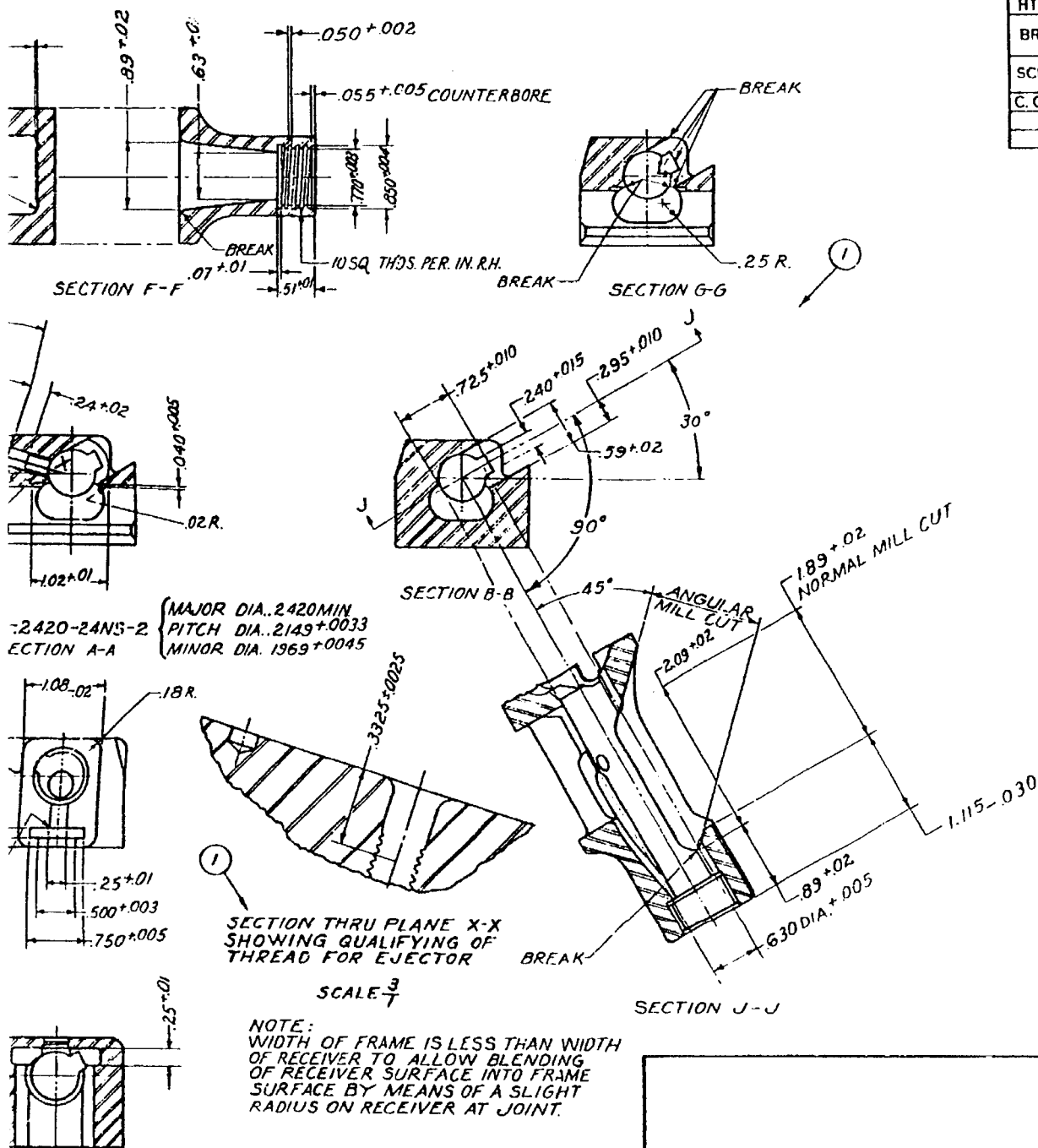


6535512
RECEIVER 35512-1
FINISH
MANUFACTURING COMPONENT

NOTES: THIS DRAWING IS A COPY OF THE ORIGINAL DRAWING AND IS NOT TO BE USED FOR MANUFACTURING PURPOSES. THE ORIGINAL DRAWING IS THE ONLY AUTHORITY FOR MANUFACTURING PURPOSES.

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
HT. T.	
BR.	
SCL.	
C. C.	

D6535512



RECEIVER 6535512
FINISH 35512-1
MANUFACTURING COMPONENT

REF. DRG. A.O.C.-45-1-2

SCALE $\frac{1}{4}$
D6535512

DECEMBER 31, 1941		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
1	12-30-43				
2	10-30-51				
SYMBOL					
DFTSMAN	TRACER	L'D.G. DFTSMAN			
CHECKER	W.S.A.	CHIEF DFTSMAN			
SUBMITTED:					
EXAMINED:					
ORD. PERTAINS TO					
51-63 45-S.M.G.-M20A1					
C64385 RECEIVER, ASSEMBLY					
ORD. DEPT. U.S.A.					
APPROVED BY ORDER OF THE CHIEF OF JUDICANCE					
J. M. A. S. CO. ORD. DEP. U.S.A.					
ORDNANCE OFFICE, WAR DEPT.					
SUPERSEDES D35512					

5

4

3

2

1

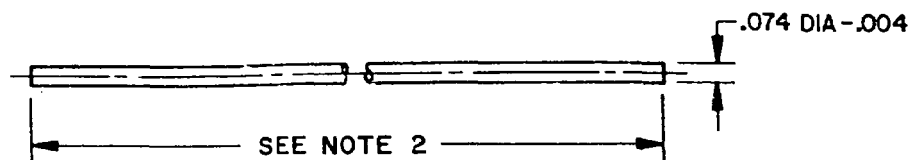
NOTES:

1. MATERIAL:

WIRE, STEEL, COMP 1010, FINISH
ANNEALED, CLASS 1, SPEC QQ-W-461.

2. LENGTH SHALL BE ADJUSTED IN
ACCORDANCE WITH METHOD OF TWISTING
TO OBTAIN REQUIREMENTS ON C6108828.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED



PART NO. 8448207

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 16 APR 68		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61204	
YP				TOLERANCES ON	DECIMALS	DRAFTSMAN A. H. Gaskill	CHECKER A. H. Gaskill	CORE	
TS				ANGLES ±	XXX ±	TRACER A. H. Gaskill	CHECKER A. H. Gaskill		
EL 2		C6108828	BRUSH, CHAMBER, CLEANING, M6	MATERIAL	SEE NOTE 1	ENGINEER Philip E. Heberle	ENGINEER P. Heberle		
RA				HEAT TREATMENT		SUBMITTED		DWG SIZE	
BH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH		APPROVED Philip E. Heberle		CODE IDENT NO.	
RH		APPLICATION				R. J. Henry		B 19204	
								SCALE 2/1	
								UNIT WT	
								SHEET 1 OF 1	

5

4

3

2

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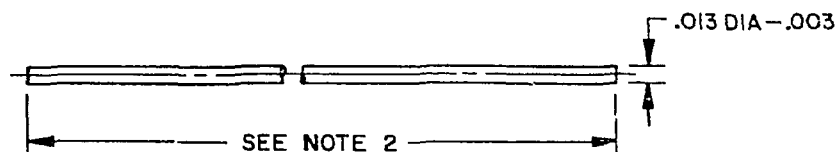
NOTES:

1. MATERIAL:

SYNTHETIC FILAMENTS, CLASS N,
TYPE II, BLACK, SPEC H-S-951.

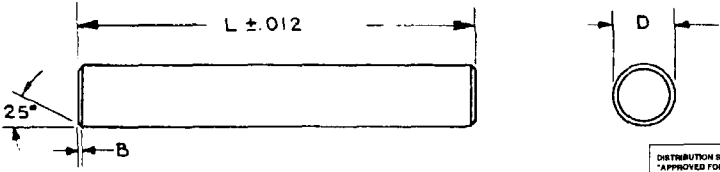
2. LENGTH SHALL BE ADJUSTED IN
ACCORDANCE WITH METHOD OF
ASSEMBLY TO OBTAIN REQUIREMENTS
ON C6108828.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE



PART NO. 8448208

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 16 APR 68		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP				TOLERANCES ON	DECIMALS	DR. DESIGN	CHECKED	BRISTLE	
TS				ANGLES ±	.XX ±	<i>L. A. Garbitt</i>	<i>C. Wilson</i>		
EL 2		C6108828	BRUSH,	MATERIAL	.XXX ±	<i>L. A. Garbitt</i>	<i>C. Wilson</i>		
RA			CHAMBER,	SEE NOTE 1		TRACER	CHECKED		
BH			CLEANING, M6	HEAT TREATMENT		ENGINEER	ENGINEER		
RH		NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH		SUBMITTED	APPROVED		
APPLICATION						<i>Philip E. Heberle</i>			
						<i>R. S. Henry</i>			
DWG SIZE		CODE IDENT NO.							
B		19204						8448208	
SCALE 10/1		UNIT WT						SHEET 1 OF 1	

PIN, STRAIGHT, STEEL CHAMFERED						BFDXI SPEC. 1-31-34 21450	
ORDNANCE CORPS STANDARDS (ORDNANCE DESIGN)						<div style="display: flex; justify-content: space-between;"> APPROVED 1-31-34 DATE </div>	
 <div style="position: absolute; bottom: 10px; right: 10px; font-size: 8px;"> DISTRIBUTION STATEMENT A: "APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED." </div>							
DIAMETER D OF PIN B CHAMFER	{ NOM. MAX. MIN.	1/16 .0630 .0620 .010	3/32 .0942 .0932 .010	1/8 .1255 .1245 .010	5/32 .1567 .1557 1/64	3/16 .1880 .1870 1/64	
<div style="font-size: 24px; font-weight: bold;">⑪ CANCELLED</div> <div style="font-weight: bold;">SUPSD BY MS51838</div>							
L LENGTH		ORDNANCE PART NUMBER - PLAIN FINISH					
1/8		505461	544188				
3/16		505462	544072	544019			
1/4		505463	505470				
5/16		505464	505471	544029			
3/8		505465	505472	505481			
7/16		505466	505473	505482	544020	544055	
1/2		505467	505474	505483	505494		
9/16		505468	505475	505484	505495	544028	
5/8		505469	505476	505485	505496	505506	
11/16			505477	505486	505497	505508	
3/4			505478	505487	505498	505509	
13/16		544070	505479	505488	505499	505510	
7/8			505480	505489	505500	505511	
15/16				505491	505501	505512	
1				505492	505502	505513	
1-1/8				505493	505503	505514	
1-1/4					505504	505515	
1-3/8					505505	505516	
1-1/2		426778				505517	
1-5/8			544075			505518	
1-3/4						505519	
L LENGTH		ORDNANCE PART NUMBER - PHOSPHATE (OILED) FINISH					
5/8						505507	
7/8				505490		582953	
1-1/8				544179			
1-3/8						582954	
3						591032	
1-5/8				592730			
MATERIAL: DRILL ROD, COMMERCIAL. TOLERANCE ON DRILL ROD $\pm .0005"$. DIMENSIONS IN INCHES. NOMENCLATURE PATTERN: PIN, STRAIGHT, DRILL ROD, 1/8" x 1/2", PLAIN, DRG. BFDXI1, PART NUMBER 505483. NOTE: PINS SHOULD BE .0005" TO .001" DRIVE FIT. FINISH: *PHOSPHATE (OILED) FINISH, TYPE II CLASS B, SPEC 57-0-2.							
ENGINEERING & INSPECTION SECTION - ORDIP				ORDNANCE DEPT., DEPT OF THE ARMY			

REVISION ⑤ 2-24-47 ⑥ 4-22-48 ⑦ 2-10-51 ⑧ 8-31-51 ⑨ 6-20-52 ⑩ 2-6-57 ⑪ 12-11-67